

Fastening Technology / Blind Rivets

# POP<sup>®</sup> Standard Blind Rivets



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# POP® Standard blind rivets

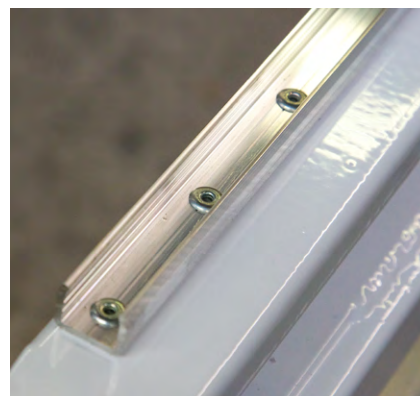


## Benefits of blind rivet installation

More and more users are recognising and applying the positive benefits of working with blind rivets: for example, in electrical, medical and mechanical engineering, household appliances, power engineering, the toy and furniture industries, or even in the automotive sector and equipment manufacturing. Unlike welded joints, which cause the material to warp, rivets can be quickly installed on one side and with little heat.

Even on hollow profiles and pipes, the joints are guaranteed to fit perfectly and maintain their dimensional accuracy. POP® blind rivets are especially suitable for thin-walled components and for effective installation from one side.

POP® standard rivets are the classic blind rivet solution. They are ideal for securely fastening multiple components, such as profiles, pipes and tanks, and much more besides. Standard blind rivets come in a wide selection of material combinations, head shapes and grip lengths. Low in cost, standard blind rivets are quickly installed and fasten tightly and securely. The stainless steel version is also very corrosion resistant.



All technical data is intended as a guide but is not binding! Subject to change without notice.

## Installation steps

1. Place the blind rivet with mandrel into the installation tool and insert into the drilled hole.
2. On triggering the installation tool, the jaws take hold of the mandrel and pull. At the same time, the mandrel head swages the end of the shank on the sleeve. The rivet is installed when the mandrel head is at the same height as the surface layer of the component.
3. A surge of force is applied at this point, causing the mandrel to snap off when it reaches its set breaking point.

## Coloured plastic caps

Plastic caps in an array of RAL colours can be supplied for the POP® blind rivet line. POP® blind rivets can also be supplied painted in the desired RAL colour.

## General building control approval

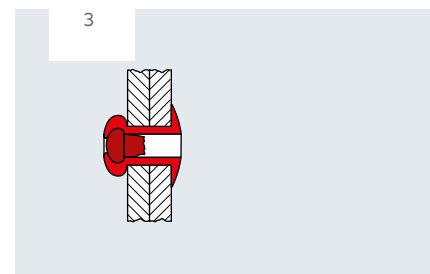
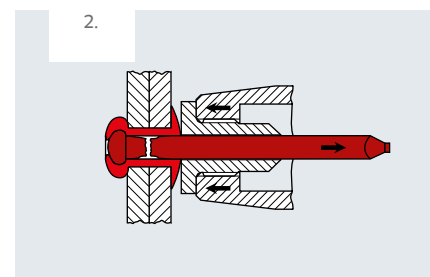
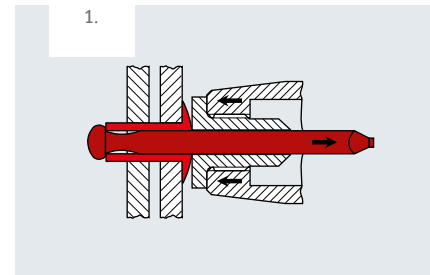
Some dimensions are available with general building control approval No. Z-14.1-4.

## Benefits at a glance

- Universal use
- Combines various materials such as metals and plastics
- Available in a very wide range of designs (dimensions, material combinations or head shapes)
- Quick and secure installation
- Permanent secure fixing
- Heatless installation means component will not warp.
- Eliminates extensive refinishing
- Ideal for lightweight constructions

## Sample applications:

- General industry
- Automotive industry
- Construction industry
- Bodywork and vehicle manufacture

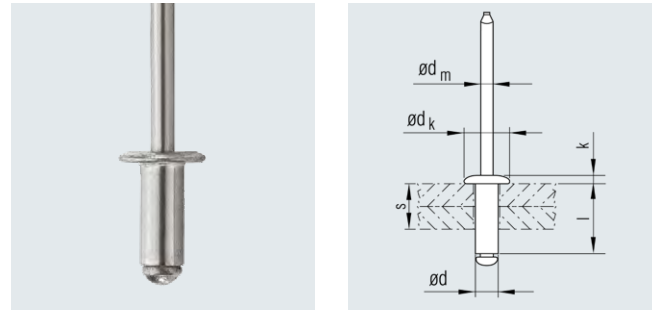


# POP® Standard blind rivets

## Truss head

### Material

■ Sleeve: Aluminum AlMg 3.5  
■ Mandrel: Steel, galvanised



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve $l \pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ dm nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.3$ [mm]	Height k $\pm 0.2$ [mm]		Shear [N]	Tensile [N]	
2.4	2.5 - 2.6	0.5 - 0.8	3.5	4.7	0.8	1.4	400	500	304 170 000
		0.8 - 2.4	5.0	4.7	0.8	1.4	400	500	304 171 000
		2.4 - 4.8	7.5	4.7	0.8	1.4	400	500	304 172 000
3.0	3.1 - 3.2	0.5 - 2.0	5.0	6.0	1.0	1.8	800	1000	301 370 000
		2.0 - 3.5	6.5	6.0	1.0	1.8	800	1000	301 371 000
		3.5 - 5.0	8.0	6.0	1.0	1.8	800	1000	301 372 000
		5.0 - 7.0	10.0	6.0	1.0	1.8	800	1000	301 373 000
		7.0 - 9.0	12.0	6.0	1.0	1.8	800	1000	301 374 000
		9.0 - 12.0	15.0	6.0	1.0	1.8	800	1000	301 375 000
3.2	3.3 - 3.4	0.5 - 1.6	4.5	6.4	1.0	1.8	800	1200	304 370 000
		1.6 - 3.2	6.0	6.4	1.0	1.8	800	1200	304 371 000
		3.2 - 4.8	8.0	6.4	1.0	1.8	800	1200	304 372 000
		4.8 - 6.4	9.7	6.4	0.92	1.83	800	1200	304 373 000
		6.4 - 7.9	11.5	6.4	1.0	1.8	800	1200	304 374 000
		7.9 - 9.5	13.5	6.4	1.0	1.8	800	1200	304 375 000
		9.5 - 11.1	15.0	6.4	1.0	1.8	800	1200	304 378 000
		11.1 - 12.7	17.0	6.4	1.0	1.8	800	1200	304 376 000
		12.7 - 14.3	18.5	6.4	1.0	1.8	800	1200	304 377 000
		14.3 - 16.7	20.0	6.4	1.0	1.8	800	1200	304 338 000
4.0	4.1 - 4.2	0.5 - 1.6	5.0	7.9	1.3	2.3	1300	1900	304 470 000
		1.6 - 3.2	7.0	7.9	1.3	2.3	1300	1900	304 471 000
		3.2 - 4.8	8.5	7.9	1.3	2.3	1300	1900	304 472 000
		4.8 - 6.4	10.5	7.9	1.3	2.3	1300	1900	304 473 000
		6.4 - 7.9	12.2	7.9	1.3	2.3	1300	1900	304 474 000
		7.9 - 9.5	14.0	7.9	1.3	2.3	1300	1900	304 475 000
		9.5 - 11.1	15.7	7.9	1.3	2.3	1300	1900	304 476 000
		11.1 - 12.7	17.5	7.9	1.3	2.3	1300	1900	304 477 000
		12.7 - 14.5	19.4	7.9	1.3	2.3	1300	1900	304 478 000
		13.5 - 15.9	20.2	7.9	1.3	2.3	1300	1900	304 479 000
		15.9 - 17.4	22.5	7.9	1.3	2.3	1300	1900	304 490 000
		17.4 - 19.8	24.7	7.9	1.3	2.3	1300	1900	304 491 000
4.8	4.9 - 5.0	0.5 - 2.4	6.5	9.5	1.4	2.6	2000	2800	304 530 000
		2.4 - 3.2	7.5	9.5	1.4	2.6	2000	2800	304 531 000
		3.2 - 4.8	9.2	9.5	1.4	2.6	2000	2800	304 532 000
		4.8 - 6.4	11.0	9.5	1.4	2.6	2000	2800	304 533 000

Continued on next page

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Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ dm nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.3$ [mm]	Height k $\pm 0.2$ [mm]		Shear [N]	Tensile [N]	
4.8	4.9 - 5.0	6.4 - 7.9	12.7	9.5	1.4	2.6	2000	2800	304 534 000
		7.9 - 9.5	14.7	9.5	1.4	2.6	2000	2800	304 535 000
		9.5 - 11.1	16.5	9.5	1.4	2.6	2000	2800	304 536 000
		11.1 - 12.7	18.0	9.5	1.4	2.6	2000	2800	304 537 000
		11.1 - 13.5	19.0	9.5	1.4	2.6	2000	2800	304 538 000
		13.5 - 15.5	21.0	9.5	1.4	2.6	2000	2800	304 564 000
		15.5 - 17.5	23.0	9.5	1.4	2.6	2000	2800	304 565 000
		13.5 - 19.8	25.5	9.5	1.4	2.6	2000	2800	304 566 000
		19.1 - 22.2	26.7	9.5	1.4	2.6	2000	2800	304 539 000
		19.8 - 26.2	32.5	9.5	1.4	2.6	2000	2800	304 567 000
5.0	5.1 - 5.2	0.5 - 3.5	6.5	9.0	1.6	2.6	2200	2600	301 531 000
		3.5 - 4.5	8.0	9.0	1.6	2.6	2200	2600	301 532 000
		4.5 - 6.0	10.0	9.0	1.6	2.6	2200	2600	301 533 000
		6.0 - 7.5	12.0	9.0	1.6	2.6	2200	2600	301 534 000
		7.5 - 9.5	14.0	9.0	1.6	2.6	2200	2600	301 535 000
		9.5 - 11.5	16.0	9.0	1.6	2.6	2200	2600	301 536 000
		11.5 - 13.5	18.0	9.0	1.6	2.6	2200	2600	301 537 000
		13.5 - 15.5	20.0	9.0	1.6	2.6	2200	2600	301 538 000
		16.5 - 17.5	22.0	9.0	1.6	2.6	2200	2600	301 539 000
17.5 - 20.5	25.0	9.0	1.6	2.6	2200	2600	301 560 000		
6.4	6.5 - 6.6	4.8 - 6.4	12.7	12.7	2.1	3.7	3200	4500	304 629 000
		9.5 - 12.7	19.5	12.7	2.1	3.7	3200	4500	304 630 000
		12.7 - 19.8	26.2	12.7	2.1	3.7	3200	4500	304 631 000
		23.2 - 25.4	31.1	12.7	1.8	3.8	3200	4500	304 632 000 <sup>1</sup>

\* Strengths at break relate to rivet failure.

<sup>1</sup> Sleeve material: AlMg 5

Other versions available on request.

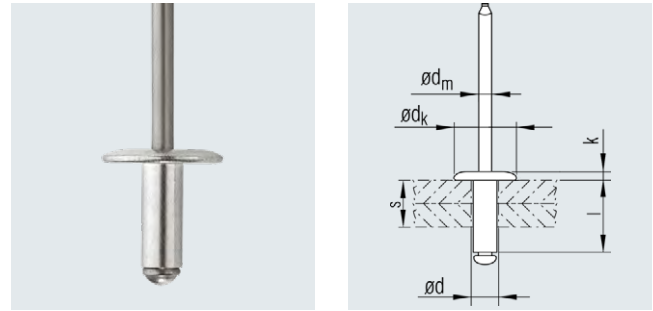
# POP® Standard blind rivets

## Large truss head

### Material

■ Sleeve:  
 Aluminum AlMg 3.5

■ Mandrel:  
 Steel, galvanised



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve $l \pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ dm nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.5$ [mm]	Height k $\pm 0.2$ [mm]		Shear [N]	Tensile [N]	
3.2	3.3 - 3.4	1.6 - 3.2	6.2	9.5	1.3	1.8	800	1200	306 371 000
		3.2 - 4.8	8.0	9.5	1.3	1.8	800	1200	306 372 000
		4.8 - 6.4	9.7	9.5	1.3	1.8	800	1200	306 373 000
		6.4 - 7.9	11.5	9.5	1.3	1.8	800	1200	306 374 000
		7.9 - 9.5	13.5	9.5	1.3	1.8	800	1200	306 375 000
		11.1 - 12.7	17.0	9.5	1.3	1.8	800	1200	306 377 000
4.0	4.1 - 4.2	1.5 - 4.8	8.5	12.0	1.4	2.3	1300	1900	306 472 000
		4.8 - 6.4	10.5	12.0	1.4	2.3	1300	1900	306 473 000
		6.4 - 7.9	12.2	12.0	1.4	2.3	1300	1900	306 474 000
		7.9 - 9.5	14.0	12.0	1.4	2.3	1300	1900	306 475 000
		9.5 - 11.1	15.7	12.0	1.4	2.3	1300	1900	306 476 000
		11.1 - 12.7	17.5	12.0	1.4	2.3	1300	1900	306 477 000
4.8	4.9 - 5.0	12.7 - 14.3	19.4	12.0	1.4	2.3	1300	1900	306 478 000
		3.2 - 4.8	9.2	11.0	1.8	2.6	2000	2800	306 532 000
		3.2 - 4.8	9.2	14.0	1.8	2.6	2000	2800	306 192 000
		4.8 - 6.4	11.0	11.0	1.8	2.6	2000	2800	306 533 000
		4.8 - 6.4	11.0	14.0	1.8	2.6	2000	2800	306 193 000
		6.4 - 7.9	12.7	11.0	1.8	2.6	2000	2800	306 534 000
		6.4 - 7.9	12.7	14.0	1.8	2.6	2000	2800	306 194 000
		7.9 - 9.5	14.5	14.0	1.8	2.6	2000	2800	306 195 000
		7.9 - 9.5	14.7	11.0	1.8	2.6	2000	2800	306 535 000
		9.5 - 11.1	16.5	11.0	1.8	2.6	2000	2800	306 536 000
		9.5 - 11.1	16.5	14.0	1.8	2.6	2000	2800	306 196 000
		11.1 - 12.7	18.2	11.0	1.8	2.6	2000	2800	306 537 000
		11.1 - 12.7	18.2	14.0	1.8	2.6	2000	2800	306 197 000
		12.7 - 13.5	19.0	11.0	1.8	2.6	2000	2800	306 538 000
12.7 - 13.5	19.0	14.0	1.8	2.6	2000	2800	306 198 000		
15.9 - 19.0	23.5	15.9	2.2	2.9	2000	2800	306 099 000 <sup>1 2</sup>		
22.3 - 25.4	29.8	15.9	2.2	2.9	2000	2800	306 101 000 <sup>1 2</sup>		

\* Strengths at break relate to rivet failure.

<sup>1</sup> Sleeve material: AlMg 5

<sup>2</sup> Tolerance for rivet head  $\varnothing dk \pm 0.7$


Other versions available on request.




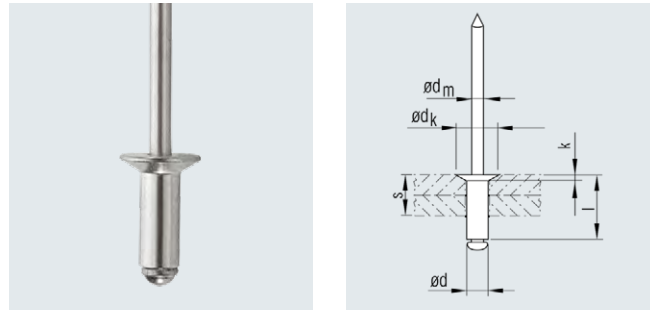
# POP® Standard blind rivets

## Countersunk 120°

### Material

 Sleeve:  
Aluminum AlMg 3.5

 Mandrel:  
Steel, galvanised



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ d <sub>m</sub> nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.4$ [mm]	Height k $\pm 0.2$ [mm]		Shear [N]	Tensile [N]	
2.4	2.5 - 2.6	1.6 - 3.2	6.0	4.7	1.0	1.4	400	500	304 180 000
		3.2 - 5.6	8.5	4.7	1.0	1.4	400	500	304 181 000
3.0	3.1 - 3.2	2.0 - 3.5	6.7	6.3	1.1	1.8	800	1000	301 381 000
3.2	3.3 - 3.4	0.5 - 2.7	5.5	6.4	1.1	1.8	800	1200	304 380 000
		2.7 - 4.3	7.5	6.4	1.1	1.8	800	1200	304 381 000
		4.3 - 5.8	9.0	6.4	1.1	1.8	800	1200	304 382 000
		5.8 - 7.4	11.0	6.4	1.1	1.8	800	1200	304 383 000
		7.4 - 9.0	12.7	6.4	1.1	1.8	800	1200	304 384 000
		9.0 - 10.6	14.5	6.4	1.1	1.8	800	1200	304 385 000
		10.6 - 12.2	16.2	6.4	1.1	1.8	800	1200	304 387 000
		12.2 - 13.8	18.0	6.4	1.1	1.8	800	1200	304 386 000
4.0	4.1 - 4.2	13.8 - 15.4	19.7	6.4	1.1	1.8	800	1200	304 388 000
		2.9 - 4.5	8.5	7.9	1.5	2.3	1300	1900	304 481 000
		4.5 - 6.1	10.0	7.9	1.5	2.3	1300	1900	304 482 000
		6.1 - 7.7	12.0	7.9	1.5	2.3	1300	1900	304 483 000
		7.7 - 9.3	13.5	7.9	1.5	2.3	1300	1900	304 484 000
		9.3 - 10.9	15.5	7.9	1.5	2.3	1300	1900	304 485 000
		10.9 - 12.4	17.0	7.9	1.5	2.3	1300	1900	304 486 000
4.8	4.9 - 5.0	12.4 - 14.0	19.0	7.9	1.5	2.3	1300	1900	304 487 000
		0.5 - 1.6	8.5	9.5	2.0	2.6	2000	2800	304 540 000
		1.6 - 4.5	9.5	9.5	2.0	2.6	2000	2800	304 541 000
		4.8 - 6.4	11.0	9.5	2.0	2.6	2000	2800	304 542 000
		6.4 - 7.9	13.0	9.5	2.0	2.6	2000	2800	304 543 000
		7.9 - 9.5	14.5	9.5	2.0	2.6	2000	2800	304 544 000
		9.5 - 11.1	16.5	9.5	2.0	2.6	2000	2800	304 545 000
		11.1 - 12.7	18.2	9.5	2.0	2.6	2000	2800	304 546 000
		14.3 - 15.1	21.0	9.5	2.0	2.6	2000	2800	304 548 000
		15.1 - 21.4	27.5	9.5	2.0	2.6	2000	2800	304 549 000
		21.4 - 27.8	34.0	9.5	2.0	2.6	2000	2800	304 589 000

\* Strengths at break relate to rivet failure.

Other designs available on request.

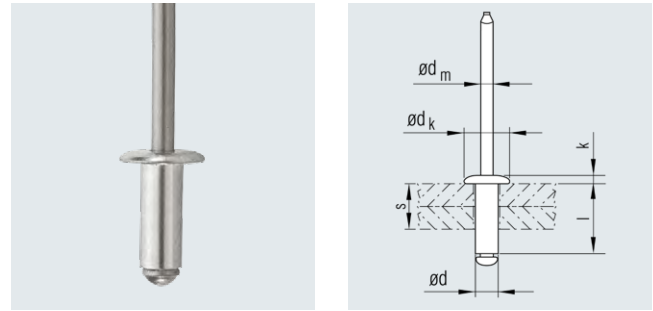
# POP® Standard blind rivets

## Truss head

## Material

Sleeve:  
 Aluminum AlMg 3.5

Mandrel:  
 Stainless steel 1.4541



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ d <sub>m</sub> nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.3$ [mm]	Height k $\pm 0.2$ [mm]		Shear [N]	Tensile [N]	
3.2	3.3 - 3.4	3.2 - 4.8	8.0	6.4	1.0	1.8	800	1200	307 372 000
		4.8 - 6.4	9.7	6.4	1.0	1.8	800	1200	307 373 000
		6.4 - 7.9	11.5	6.4	1.0	1.8	800	1200	307 374 000
4.0	4.1 - 4.2	3.2 - 4.8	8.5	7.9	1.3	2.3	1300	1900	307 472 000
		4.8 - 6.4	10.5	7.9	1.3	2.3	1300	1900	307 473 000
		6.4 - 7.9	12.2	7.9	1.3	2.3	1300	1900	307 474 000
		7.9 - 9.5	14.0	7.9	1.3	2.3	1300	1900	307 475 000
4.8	4.9 - 5.0	2.4 - 3.2	7.5	9.5	1.6	2.6	2000	2800	307 531 000
		3.2 - 4.8	9.2	9.5	1.6	2.6	2000	2800	307 532 000
		4.8 - 6.4	11.0	9.5	1.6	2.6	2000	2800	307 533 000
		6.4 - 7.9	12.7	9.5	1.6	2.6	2000	2800	307 534 000
		7.9 - 9.5	14.7	9.5	1.6	2.6	2000	2800	307 535 000
		9.5 - 11.1	16.5	9.5	1.6	2.6	2000	2800	307 536 000
		11.1 - 13.5	19.0	9.5	1.6	2.6	2000	2800	307 538 000

\* Strengths at break relate to rivet failure.

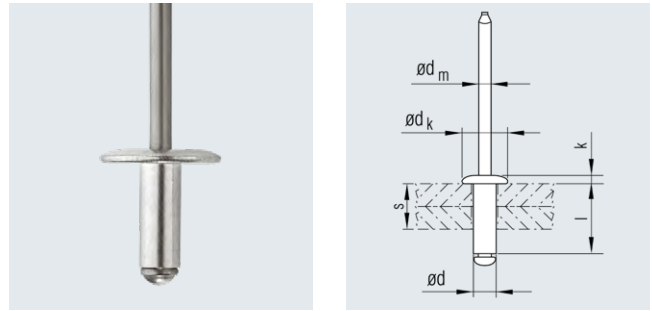
Other designs available on request.

# POP® Standard blind rivets

## Large truss head

### Material

	
Sleeve: Aluminum AlMg 3.5	Mandrel: Stainless steel 1.4541



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ d <sub>m</sub> nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.3$ [mm]	Height k $\pm 0.2$ [mm]		Shear [N]	Tensile [N]	
4.8	4.9 - 5.0	3.2 - 4.8	9.2	11.0	2.0	2.6	2000	2800	307 232 000
		4.8 - 6.4	11.0	14.3	2.0		2000	2800	307 193 000
		6.4 - 7.9	12.7	14.3	2.0		2000	2800	307 194 000

\* Strengths at break relate to rivet failure.

Other designs available on request.

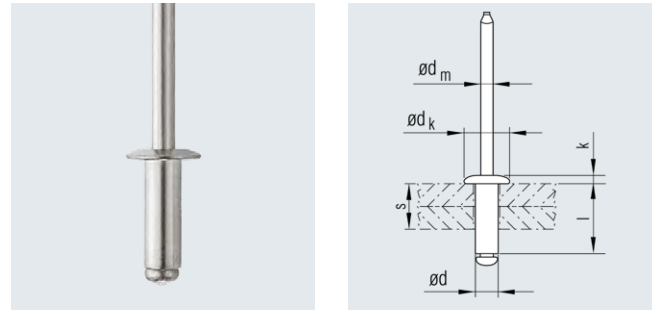
# POP® Standard blind rivets

## Truss head

### Material

Sleeve:  
 Aluminum AlMg 2.5

Mandrel:  
 Aluminium



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve $l \pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ dm nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.5$ [mm]	Height k $\pm 0.2$ [mm]		Shear [N]	Tensile [N]	
2.4	2.5	0.8 - 3.2	5.7	4.8	0.8	1.5	400	500	302 130 000
		3.2 - 6.4	8.9	4.8	0.8	1.5	400	500	302 131 000
		6.4 - 9.5	12.1	4.8	0.8	1.5	400	500	302 132 000
3.2	3.3 - 3.4	0.8 - 1.6	4.8	6.3	1.0	1.9	680	1040	302 330 000
		1.6 - 3.2	6.4	6.3	1.0	1.9	680	1040	302 331 000
		3.2 - 4.8	8.0	6.3	1.0	1.9	680	1040	302 332 000
		4.8 - 6.4	9.5	6.3	1.0	1.9	680	1040	302 333 001
		6.4 - 7.9	11.1	6.3	1.0	1.9	680	1040	302 334 000
		7.9 - 9.5	12.7	6.3	1.0	1.9	680	1040	302 335 000
		9.5 - 12.7	15.9	6.3	1.0	1.9	680	1040	302 336 000
4.0	4.1 - 4.2	1.6 - 3.2	7.0	8.0	1.2	2.4	1000	1550	302 432 000
		3.2 - 4.8	8.6	8.0	1.2	2.4	1000	1550	302 435 000
		4.8 - 6.4	10.2	8.0	1.2	2.4	1000	1550	302 433 000
		6.4 - 9.5	13.3	8.0	1.2	2.4	1000	1550	302 434 000
		9.5 - 12.7	16.5	8.0	1.2	2.4	1000	1550	302 436 000
4.8	4.9 - 5.0	1.6 - 3.2	7.6	9.5	1.4	2.9	1400	2220	302 531 000
		3.2 - 6.4	10.8	9.5	1.4	2.9	1400	2220	302 532 000
		6.4 - 9.5	14.0	9.5	1.4	2.9	1400	2220	302 533 000
		9.5 - 12.7	17.1	9.5	1.4	2.9	1400	2220	302 534 000
		12.7 - 15.9	20.3	9.5	1.4	2.9	1400	2220	302 535 000
		15.9 - 19.1	23.5	9.5	1.4	2.9	1400	2220	302 536 000
		22.2 - 25.4	29.8	9.5	1.4	2.9	1400	2220	302 537 000

\* Strengths at break relate to rivet failure.

Other designs available on request.

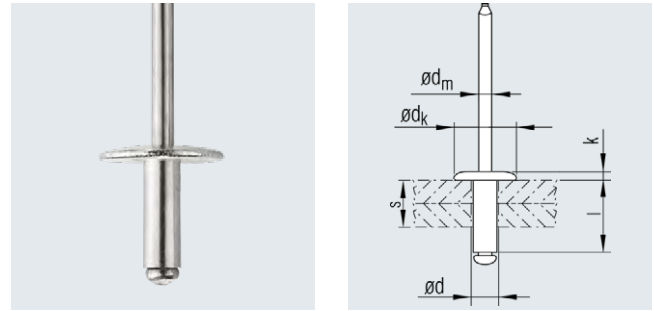
# POP® Standard blind rivets

## Large truss head

### Material

Sleeve:  
Aluminum AlMg 2.5

Mandrel:  
Aluminium



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ dm nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.6$ [mm]	Height k $\pm 0.2$ [mm]		Shear [N]	Tensile [N]	
3.2	3.3 - 3.4	3.2 - 6.4	9.5	9.5	1.6	1.9	680	1000	306 202 000
4.0	4.1 - 4.2	4.8 - 6.4	10.2	12.0	1.9	2.4	1000	1500	306 213 000
4.8	4.9 - 5.0	3.2 - 6.4	10.8	15.9	2.3	2.9	1400	2200	306 221 000
		6.4 - 9.5	14.0	15.9	2.3	2.9	1400	2200	306 222 000
		9.5 - 12.7	17.2	15.9	2.3	2.9	1400	2200	306 223 000
		12.7 - 15.9	20.3	15.9	2.3	2.9	1400	2200	306 224 000
		15.9 - 19.1	23.5	15.9	2.3	2.9	1400	2200	306 225 000

\* Strengths at break relate to rivet failure.

Other designs available on request.

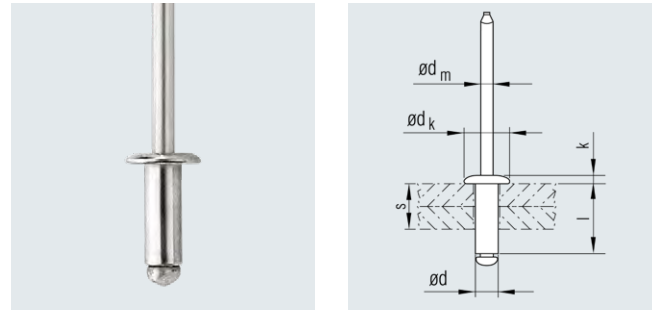
# POP® Standard blind rivets

## Truss head

## Material

Sleeve:  
Steel, galvanised,  
passivated

Mandrel:  
Steel, galvanised,



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ d <sub>m</sub> nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.3$ [mm]	Height k $\pm 0.3$ [mm]		Shear [N]	Tensile [N]	
2.4	2.5	0.5 - 2.9	5.3	4.6	0.8	1.5	700	900	304 701 900
		3.2 - 6.4	8.9	4.6	0.8	1.5	700	900	304 002 900
3.0	3.1 - 3.2	0.5 - 2.0	5.0	6.0	1.0	1.8	1100	1400	301 710 900
		2.0 - 3.5	6.5	6.0	1.0	1.8	1100	1400	301 711 900
		3.5 - 5.0	8.0	6.0	1.0	1.8	1100	1400	301 712 900
		5.0 - 7.0	10.0	6.0	1.0	1.8	1100	1400	301 713 900
		7.0 - 9.0	12.0	6.0	1.0	1.8	1100	1400	301 714 900
3.2	3.3 - 3.4	9.0 - 12.0	15.0	6.0	1.0	1.8	1100	1400	301 715 900
		0.5 - 1.6	4.5	6.4	1.0	1.9	1150	1550	304 710 900
		1.6 - 3.2	6.0	6.4	1.0	1.9	1150	1550	304 711 900
		3.2 - 4.8	8.0	6.4	1.0	1.9	1150	1550	304 712 900
		4.8 - 6.4	9.5	6.4	1.0	1.9	1150	1550	306 935 900
		6.4 - 7.9	11.5	6.4	1.0	1.9	1150	1550	304 714 900
4.0	4.1 - 4.2	7.9 - 9.5	13.5	6.4	1.0	1.9	1150	1550	304 715 900
		9.5 - 11.1	15.0	6.4	1.0	1.9	1150	1550	304 716 900
		0.5 - 1.6	5.0	8.0	1.2	2.3	1730	2500	304 730 900
		1.6 - 3.2	7.0	8.0	1.2	2.3	1730	2500	306 961 900
		3.2 - 4.8	8.5	8.0	1.2	2.3	1730	2500	306 932 900
		4.8 - 6.4	10.5	8.0	1.2	2.3	1730	2500	304 733 900
		6.4 - 7.9	12.2	8.0	1.2	2.3	1730	2500	304 734 900
4.8	4.9 - 5.0	7.9 - 9.5	14.0	8.0	1.2	2.3	1730	2500	304 735 900
		9.5 - 11.1	15.9	8.0	1.2	2.3	1730	2500	304 736 900
		0.5 - 2.4	6.5	9.5	1.6	2.9	2600	3500	304 750 900
		2.4 - 3.2	7.5	9.5	1.6	2.9	2600	3500	304 751 900
		3.2 - 4.8	9.3	9.5	1.6	2.9	2600	3500	304 752 900
		4.8 - 6.4	11.0	9.5	1.6	2.9	2600	3500	304 753 900
		6.4 - 7.9	12.7	9.5	1.6	2.9	2600	3500	304 754 900
		7.9 - 9.5	14.5	9.5	1.6	2.9	2600	3500	304 755 900
		9.5 - 11.1	16.5	9.5	1.6	2.9	2600	3500	304 756 900
5.0	5.1 - 5.2	12.7 - 13.5	19.0	9.5	1.6	2.9	2600	3500	304 757 900
		22.3 - 25.4	29.8	9.5	1.6	2.9	2600	3500	304 058 900
		2.5 - 4.0	8.0	9.0	1.6	2.9	2800	3700	301 751 900
		4.0 - 6.0	10.0	9.0	1.6	2.9	2800	3700	301 752 900
		6.0 - 8.0	12.0	9.0	1.6	2.9	2800	3700	301 753 900
		8.0 - 10.0	14.0	9.0	1.6	2.9	2800	3700	301 754 900
		10.0 - 12.0	16.0	9.0	1.6	2.9	2800	3700	301 755 900

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Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ dm nom. [mm]	Nominal strength at break		Article No.	
				$\varnothing$ dk $\pm 0.3$ [mm]	Height k $\pm 0.3$ [mm]		Shear [N]	Tensile [N]		
5.0	5.1 - 5.2	12.0 - 14.0	18.0	9.0	1.6	2.9	2800	3700	301 756 900	
6.0	6.1 - 6.2	4.0 - 6.0	12.0	12.0	2.1	3.7	4200	5500	301 853 900	
		6.0 - 8.0	14.0	12.0	2.1	3.7	4200	5500	301 854 900	
6.4	6.5 - 6.7	0.5 - 3.8	9.5	11.0	1.6	3.9	5000	5700	304 071 901	
		3.8 - 7.6	13.0	11.0	1.6	3.9	5000	5700	304 072 901	
		7.6 - 12.7	18.5	11.0	1.6	3.9	5000	5700	304 073 901	
	6.5 - 6.6	12.7 - 15.9	21.6	12.7	12.7	1.6	3.9	5000	5700	304 074 900 <sup>1</sup>
		15.9 - 19.1	24.8	12.7	12.7	1.6	3.9	5000	5700	304 075 900 <sup>1</sup>
		23.2 - 25.4	31.1	12.7	12.7	1.6	3.9	5000	5700	304 076 900 <sup>1</sup>

\* Strengths at break relate to rivet failure.

<sup>1</sup> Tolerance for rivet head  $\varnothing$  dk  $\pm 0.7$ 

Other versions available on request.

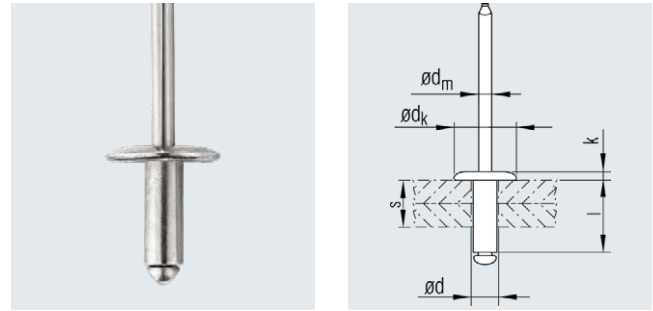
# POP® Standard blind rivets

## Large truss head

### Material

Sleeve:  
Steel, galvanised,  
passivated

Mandrel:  
Steel, galvanised,



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ d <sub>m</sub> nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.3$ [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
3.2	3.3 - 3.4	3.2 - 4.8	8.0	9.5	1.5	1.9	1150	1550	306 012 900
		4.8 - 6.4	9.8	9.5	1.5		1150	1550	306 013 900
4.0	4.1 - 4.2	3.2 - 4.8	8.5	12.0	1.7	2.3	1730	2500	306 032 900
		4.8 - 6.4	10.5	12.0	1.7		1730	2500	306 033 900
		6.4 - 7.9	12.2	12.0	1.7		1730	2500	306 034 900
		7.9 - 9.5	14.0	12.0	1.7		1730	2500	306 035 900
		9.5 - 11.1	15.9	12.0	1.7		1730	2500	306 036 900
4.8	4.9 - 5.0	0.5 - 3.2	7.5	14.0	2.0	2.9	2600	3500	306 051 900
		3.2 - 4.8	9.3	14.0	2.0		2600	3500	306 052 900
		4.8 - 6.4	11.0	14.0	2.0		2600	3500	306 053 900
		6.4 - 7.9	12.7	14.0	2.0		2600	3500	306 054 900
		7.9 - 9.5	14.5	14.0	2.0		2600	3500	306 055 900
		9.5 - 11.1	16.5	14.0	2.0		2600	3500	306 056 900
		11.1 - 13.5	19.0	14.0	2.0		2600	3500	306 057 900
15.9 - 19.1	23.5	15.9	2.4	2600	3500	306 187 900 <sup>1</sup>			

\* Strengths at break relate to rivet failure.

<sup>1</sup> Tolerance for rivet head  $\varnothing$  dk  $\pm 0.7$

Other versions available on request.



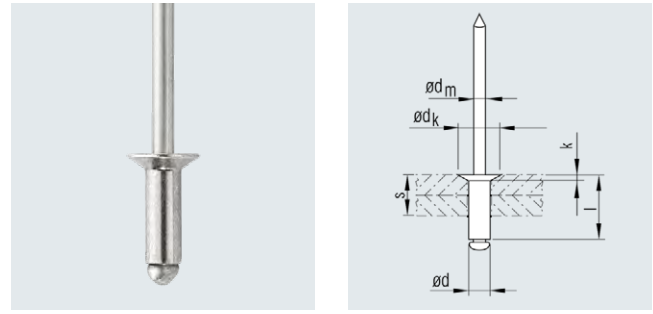
# POP® Standard blind rivets

## Countersunk 120°

### Material

Sleeve:  
Steel, galvanised,  
passivated

Mandrel:  
Steel, galvanised,



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ dm nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.4$ [mm]	Height k $\pm 0.2$ [mm]		Shear [N]	Tensile [N]	
2.4	2.5 - 2.6	0.8 - 3.2	6.1	4.7	0.8	1.4	700	1000	304 706 900
		3.1 - 6.0	8.5	4.7	0.8	1.4	700	1000	304 707 900
3.2	3.3 - 3.4	0.8 - 2.7	5.4	6.3	1.0	1.9	1100	1500	304 720 900
		2.7 - 4.3	7.3	6.3	1.0	1.9	1100	1500	304 721 900
		4.3 - 5.8	9.0	6.3	1.0	1.9	1100	1500	304 722 900
		5.8 - 7.4	10.8	6.3	1.0	1.9	1100	1500	304 723 900
		7.4 - 9.0	12.6	6.3	1.0	1.9	1100	1500	304 724 900
		9.0 - 10.6	14.4	6.3	1.0	1.9	1100	1500	304 725 900
4.0	4.1 - 4.2	0.5 - 2.9	6.5	8.0	1.5	2.3	1700	2500	304 740 900
		2.9 - 4.5	8.5	8.0	1.5	2.3	1700	2500	304 741 900
		4.5 - 6.1	10.0	8.0	1.5	2.3	1700	2500	304 742 900
		6.1 - 7.7	12.0	8.0	1.5	2.3	1700	2500	304 743 900
		7.7 - 9.3	13.5	8.0	1.5	2.3	1700	2500	304 744 900
		9.3 - 10.9	15.5	8.0	1.5	2.3	1700	2500	304 745 900
4.8	4.9 - 5.0	10.9 - 12.4	17.0	8.0	1.5	2.3	1700	2500	304 746 900
		0.8 - 2.4	8.4	9.5	1.8	2.9	2600	3500	304 760 900
		2.4 - 4.8	9.3	9.5	1.8	2.9	2600	3500	304 761 900
		4.8 - 6.4	11.1	9.5	1.8	2.9	2600	3500	304 762 900
		6.4 - 7.9	12.8	9.5	1.8	2.9	2600	3500	304 763 900
		7.9 - 9.5	14.6	9.5	1.8	2.9	2600	3500	304 764 900
6.4	6.6	9.5 - 11.1	16.4	9.5	1.8	2.9	2600	3500	304 765 900
		11.1 - 12.7	18.2	9.5	1.8	2.9	2600	3500	304 766 900
		14.3 - 15.1	21.0	9.5	1.8	2.9	2600	3500	304 767 900
		0.3 - 3.8	9.5	10.9	1.6	3.9	4700	6500	304 081 901
6.4	6.6	3.8 - 8.9	13.0	10.9	1.6	3.9	4700	6500	304 082 901
		8.9 - 13.5	18.5	10.9	1.6	3.9	4700	6500	304 083 901

\* Strengths at break relate to rivet failure.

† Tolerance for rivet head  $\varnothing$  dk  $\pm 0.7$

Other versions available on request.

# POP® Standard blind rivets

## Truss head

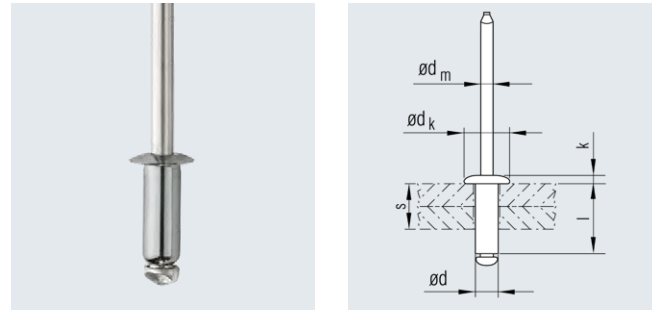
## Material



Sleeve:  
Nickel/copper  
70/30 alloy, galvanised



Mandrel:  
Steel, galvanised,



Nominal $\varnothing$ $d$ [mm]	Bore $\varnothing$ [mm]	Grip range $s$ [mm]	Blind sleeve $l \pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ $d_m$ nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ $dk \pm 0.3$ [mm]	Height $k$ max. [mm]		Shear [N]	Tensile [N]	
2.8	2.9 - 3.0	0.5 - 1.8	5.0	4.9	0.6	1.8	1150	1300	304 210 000
		1.8 - 2.3	5.5	4.9	0.6	1.8	1150	1300	304 211 000
3.2	3.3 - 3.4	0.5 - 1.8	5.0	6.0	0.8	1.9	1500	1900	304 310 001
		1.8 - 3.1	6.2	6.0	0.8	1.9	1500	1900	304 311 001
		3.1 - 4.3	7.5	6.0	0.8	1.9	1500	1900	304 312 001
		4.3 - 5.8	9.0	6.0	0.8	1.9	1500	1900	304 313 001
		5.8 - 7.1	10.3	6.0	0.8	1.9	1500	1900	304 314 001
4.0	4.1 - 4.2	2.5 - 4.1	7.8	6.8	0.8	2.3	2200	3000	304 412 000
		4.1 - 5.8	9.5	6.8	0.8	2.3	2200	3000	304 413 000
		5.8 - 6.6	10.3	6.8	0.8	2.3	2200	3000	304 414 000
		6.6 - 7.9	11.5	6.8	0.8	2.3	2200	3000	304 415 001
4.8	4.9 - 5.0	2.3 - 3.8	7.7	8.1	1.3	2.9	3000	3750	304 511 001
		3.8 - 5.1	9.3	8.1	1.3	2.9	3000	3750	304 512 001
		5.1 - 5.8	10.0	8.1	1.3	2.9	3000	3750	304 513 001
		5.8 - 8.6	12.8	8.1	1.3	2.9	3000	3750	304 514 001
		8.6 - 12.5	16.5	8.1	1.3	2.9	3000	3750	304 515 001
6.4	6.5 - 6.7	4.0 - 7.6	12.8	10.8	1.6	3.9	5400	6750	304 611 000
		7.6 - 13.5	18.0	10.8	1.6	3.9	5400	6750	304 612 000

\* Strengths at break relate to rivet failure.

The 70/30 nickel/copper alloy used in POP® blind rivets is equivalent to Monel®.

POP® standard open sleeves made of 70/30 nickel/copper alloy are additionally galvanised to further enhance the products' resistance.

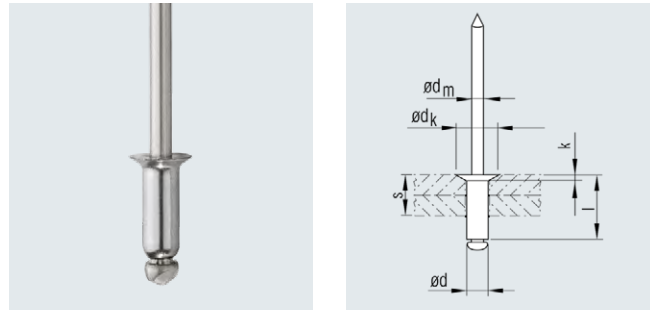
Other designs available on request.

# POP® Standard blind rivets

## Countersunk 120°

### Material

	
Sleeve: Nickel/copper 70/30 alloy, galvanised	Mandrel: Steel, galvanised,



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ d <sub>m</sub> nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.3$ [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
2.8	2.9 - 3.0	2.3 - 2.8	6.0	5.0	1.0	1.8	1150	1300	304 221 000
3.2	3.3 - 3.4	0.8 - 2.5	5.8	6.0	1.0	1.9	1500	1900	304 320 001
		2.5 - 3.8	7.0	6.0	1.0	1.9	1500	1900	304 321 001
		3.8 - 5.1	8.5	6.0	1.0	1.9	1500	1900	304 322 000
		5.1 - 6.6	10.0	6.0	1.0	1.9	1500	1900	304 323 001
		6.6 - 7.9	11.2	6.0	1.0	1.9	1500	1900	304 324 000
4.0	4.1 - 4.2	2.0 - 3.3	7.2	6.9	1.1	2.3	2200	3000	304 421 000
		3.3 - 4.8	8.7	6.9	1.1	2.3	2200	3000	304 422 000
		4.8 - 6.6	10.5	6.9	1.1	2.3	2200	3000	304 423 000
		6.6 - 7.4	11.3	6.9	1.1	2.3	2200	3000	304 424 000
		7.4 - 8.6	12.5	6.9	1.1	2.3	2200	3000	304 425 000
4.8	4.9 - 5.0	3.1 - 4.6	9.0	8.3	1.3	2.9	3300	3750	304 521 000
		4.6 - 5.8	10.5	8.3	1.3	2.9	3300	3750	304 522 000
		5.8 - 6.6	11.0	8.3	1.3	2.9	3300	3750	304 523 000
		6.6 - 9.4	14.0	8.3	1.3	2.9	3300	3750	304 524 000
		9.4 - 13.2	18.0	8.3	1.3	2.9	3300	3750	304 525 000
6.4	6.5 - 6.7	4.6 - 8.4	14.5	11.0	1.8	3.9	5400	6750	304 621 000
		8.4 - 13.5	19.4	11.0	1.8	3.9	5400	6750	304 622 000

\* Strengths at break relate to rivet failure.

The 70/30 nickel/copper alloy used in POP® blind rivets is equivalent to Monel®.

POP® standard open sleeves made of 70/30 nickel/copper alloy are additionally galvanised to further enhance the products' resistance.

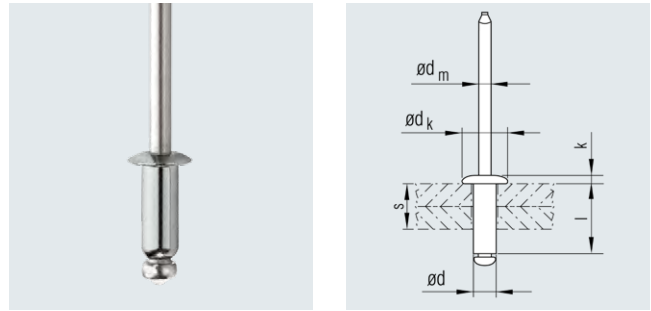
Other designs available on request.

# POP® Standard blind rivets

## Truss head

## Material

	
Sleeve: Nickel/copper 70/30 alloy, galvanised	Mandrel: Stainless steel 1.4303



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ d <sub>m</sub> nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.3$ [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
3.2	3.3 - 3.4	1.8 - 3.1	6.2	6.0	0.8	1.9	1500	1900	307 351 001
		3.1 - 4.3	7.5	6.0	0.8	1.9	1500	1900	307 352 001
		4.3 - 5.8	9.0	6.0	0.8	1.9	1500	1900	307 353 001
		5.8 - 7.1	10.3	6.0	0.8	1.9	1500	1900	307 354 001
4.0	4.1 - 4.2	1.3 - 2.5	6.2	6.7	1.2	2.3	2200	3000	307 411 000
		2.5 - 4.1	7.8	6.7	1.2	2.3	2200	3000	307 412 000
		4.1 - 5.9	9.5	6.7	1.2	2.3	2200	3000	307 413 000
		5.8 - 6.6	10.3	6.7	1.2	2.3	2200	3000	307 414 000
		6.6 - 7.9	11.5	6.7	1.2	2.3	2200	3000	307 415 000
4.8	4.9 - 5.0	0.5 - 2.3	6.2	8.1	1.3	2.9	3300	3750	307 510 000
		2.3 - 3.8	7.7	8.1	1.3	2.9	3300	3750	307 511 001
		3.8 - 5.1	9.3	8.1	1.3	2.9	3300	3750	307 512 001
		5.1 - 5.8	10.0	8.1	1.3	2.9	3300	3750	307 513 001
		5.8 - 8.6	12.8	8.1	1.3	2.9	3300	3750	307 514 001
		8.6 - 12.5	16.5	8.1	1.3	2.9	3300	3750	307 515 000
		12.5 - 15.0	19.0	8.1	1.3	2.9	3300	3750	307 516 001

\* Strengths at break relate to rivet failure.

The 70/30 nickel/copper alloy used in POP® blind rivets is equivalent to Monel®.

POP® standard open sleeves made of 70/30 nickel/copper alloy are additionally galvanised to further enhance the products' resistance.

Other designs available on request.

# POP® Standard blind rivets

## Truss head

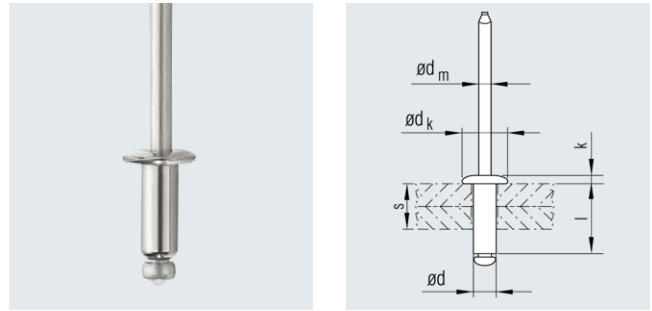
## Material

Sleeve:

Stainless steel 1.4303

Mandrel:

Stainless steel 1.4541



Nominal $\varnothing$ $d$ [mm]	Bore $\varnothing$ [mm]	Grip range $s$ [mm]	Blind sleeve $l \pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ $d_m$ nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ $dk \pm 0.5$ [mm]	Height $k \pm 0.2$ [mm]		Shear [N]	Tensile [N]	
3.2	3.3 - 3.4	3.2 - 4.8	8.0	6.4	0.9	1.9	2400	3000	303 312 000
		4.8 - 6.4	9.5	6.4	0.9	1.9	2400	3000	303 313 000
		6.4 - 9.5	12.7	6.4	0.9	1.9	2400	3000	303 314 000
		9.5 - 12.7	15.9	6.4	0.9	1.9	2400	3000	303 315 000
4.0	4.1 - 4.2	1.6 - 3.2	7.0	8.0	1.1	2.4	4000	5000	303 411 000
		3.2 - 6.4	10.2	8.0	1.1	2.4	4000	5000	303 412 000
		6.4 - 9.5	13.3	8.0	1.1	2.4	4000	5000	303 413 000
4.8	4.9 - 5.0	1.6 - 3.2	7.6	9.5	1.3	2.9	4400	6100	303 511 000
		3.2 - 6.4	10.8	9.5	1.3	2.9	4400	6100	303 512 000
		6.4 - 9.5	14.0	9.5	1.3	2.9	4400	6100	303 513 000
		9.5 - 12.7	17.2	9.5	1.3	2.9	4400	6100	303 514 000

\* Strengths at break relate to rivet failure.

Other designs available on request.

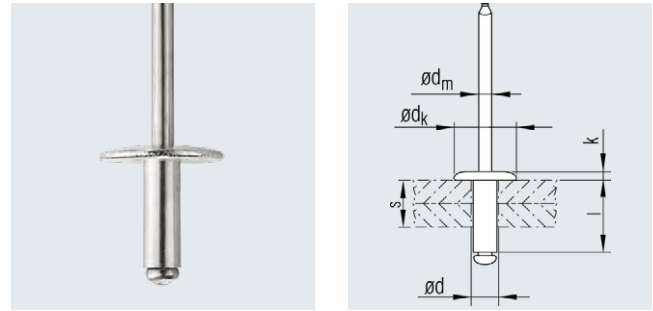
# POP® Standard blind rivets

## Large truss head

### Material

Sleeve:  
 Stainless steel 1.4303

Mandrel:  
 Stainless steel 1.4541



Nominal $\emptyset$ d [mm]	Bore $\emptyset$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\emptyset$ d <sub>m</sub> nom. [mm]	Nominal strength at break		Article No.
				$\emptyset$ dk $\pm 0.3$ [mm]	Height k $\pm 0.2$ [mm]		Shear [N]	Tensile [N]	
3.2	3.3 - 3.4	1.6 - 3.2	6.4	9.9	1.5	1.9	2400	3000	303 930 000
		4.8 - 6.4	9.5	9.9	1.5		2400	3000	

\* Strengths at break relate to rivet failure.

Other designs available on request.

# POP® Standard blind rivets

## Truss head

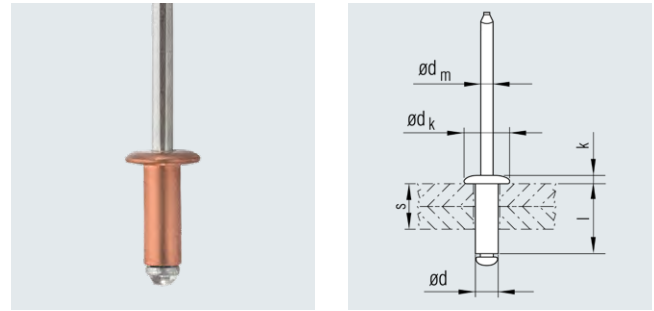
## Material



Sleeve:  
Copper



Mandrel:  
Steel



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l $\pm 0.5$ [mm]	Blind rivet head		Mandrel $\varnothing$ d <sub>m</sub> nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk $\pm 0.3$ [mm]	Height k $\pm 0.2$ [mm]		Shear [N]	Tensile [N]	
3.2	3.3 - 3.4	2.1 - 2.9	6.3	6.2	1.0	1.8	800	1200	304 971 000
		2.9 - 4.5	8.0	6.2	1.0				
4.0	4.1 - 4.2	0.5 - 3.2	7.0	8.0	1.2	2.3	1300	1900	304 961 000

\* Strengths at break relate to rivet failure.

Other designs available on request.

## About us

The Titgemeyer Group is a leading company for fastening technology and vehicle components at 15 locations in Europe.

The traditional company develops, manufactures and sells more than 30,000 fastening elements, tools and vehicle components – in series production and on request.

### Headquarters

**Titgemeyer GmbH & Co. KG**  
Hannoversche Straße 97  
49084 Osnabrück / DE

PO Box 4320  
49033 Osnabrück / DE

T +49 541 5822-0  
E [info@titgemeyer.com](mailto:info@titgemeyer.com)  
W [titgemeyer.com](http://titgemeyer.com)



### Sales locations

**Titgemeyer Austria GmbH**  
Brunner Straße 77 - 79  
1230 Wien / AT

T +43 (0) 1/6 67 90 40 - 0  
E [sales@titgemeyer.com](mailto:sales@titgemeyer.com)  
W [titgemeyer.at](http://titgemeyer.at)

**Titgemeyer CZ spol. s r. o.**  
U Vodárny 1506  
397 01 Písek / CZ

T +420 382 2067 - 25  
E [sales@titgemeyer.com](mailto:sales@titgemeyer.com)  
W [titgemeyercz.cz](http://titgemeyercz.cz)

**Titgemeyer Polska sp. z o.o.**  
Cypriana Bazylika 17  
98-200 Sieradz / PL

T +48 (0) 43 828 20 - 15  
E [sales@titgemeyer.com](mailto:sales@titgemeyer.com)  
W [titgemeyer.pl](http://titgemeyer.pl)

**Titgemeyer Skandinavien A/S**  
Lunikvej 32  
2670 Greve / DK

T +45 4360 0966  
E [info@titgemeyer.dk](mailto:info@titgemeyer.dk)  
W [titgemeyer.dk](http://titgemeyer.dk)

**Titgemeyer Skandinavien A/S**  
Box 3218  
550 03 Jönköping / SE

T +46 36 128350  
E [info@titgemeyer.se](mailto:info@titgemeyer.se)  
W [titgemeyer.se](http://titgemeyer.se)

**Titgemeyer Skandinavien A/S**  
Korkeakoulunkatu 7  
33720 Tampere / FI

T +358 (0) 400 448 401  
E [info@titgemeyer.fi](mailto:info@titgemeyer.fi)  
W [titgemeyer.fi](http://titgemeyer.fi)

**Titgemeyer Turkey Baglanti Teknolojileri San. ve Tic. A.S.**  
Barbaros Mah. Is Merkezi No.1  
Kat: 8 D.58  
34746 Atasehir, Istanbul / TUR

T +90 (0) 21 66 88 20 - 27  
E [sales@titgemeyer.com.tr](mailto:sales@titgemeyer.com.tr)  
W [titgemeyer.com.tr](http://titgemeyer.com.tr)

**Titgemeyer (UK) Limited**  
A2 Link One Industrial Park  
George Henry Road  
DY4 7BU Tipton / UK

T +44 (0) 1 21 5 57 97 - 77  
E [sales@titgemeyer.co.uk](mailto:sales@titgemeyer.co.uk)  
W [titgemeyer.co.uk](http://titgemeyer.co.uk)

### Production sites

**Cirteq Limited**  
'Hayfield' Colne Road,  
Glusburn, Keighley,  
West Yorkshire, BD20 8QP

T +44 1535 633333  
E [sales@cirteq.com](mailto:sales@cirteq.com)  
W [cirteq.com](http://cirteq.com)

**Titgemeyer Tools & Automation spol s.r.o.**  
U Vodárny 1506  
397 01 Písek / CZ

T +42 382 2067 - 11  
E [info@rivetec.cz](mailto:info@rivetec.cz)  
W [rivetec.cz](http://rivetec.cz)

**RIEKO GmbH**  
Robert-Bosch-Straße 9  
72124 Pliezhausen / DE

T +49 7127 9744 - 0  
E [info@rieko-web.com](mailto:info@rieko-web.com)  
W [rieko-web.com](http://rieko-web.com)

**Titgemeyer GmbH & Co. KG Werk Lotte**  
Daimlerstraße 13 - 15  
49504 Lotte / DE

T +49 5404 9666 - 0  
E [info@titgemeyer.com](mailto:info@titgemeyer.com)  
W [titgemeyer.com](http://titgemeyer.com)

**TS Gesellschaft für Transport- und Sicherungssysteme mbH**  
Haßlinghauser Straße 156  
58285 Gevelsberg / DE

T +49 541 5822 - 900  
E [ts@cargocontrol.de](mailto:ts@cargocontrol.de)  
W [wir-sind-ladungssicherung.de](http://wir-sind-ladungssicherung.de)