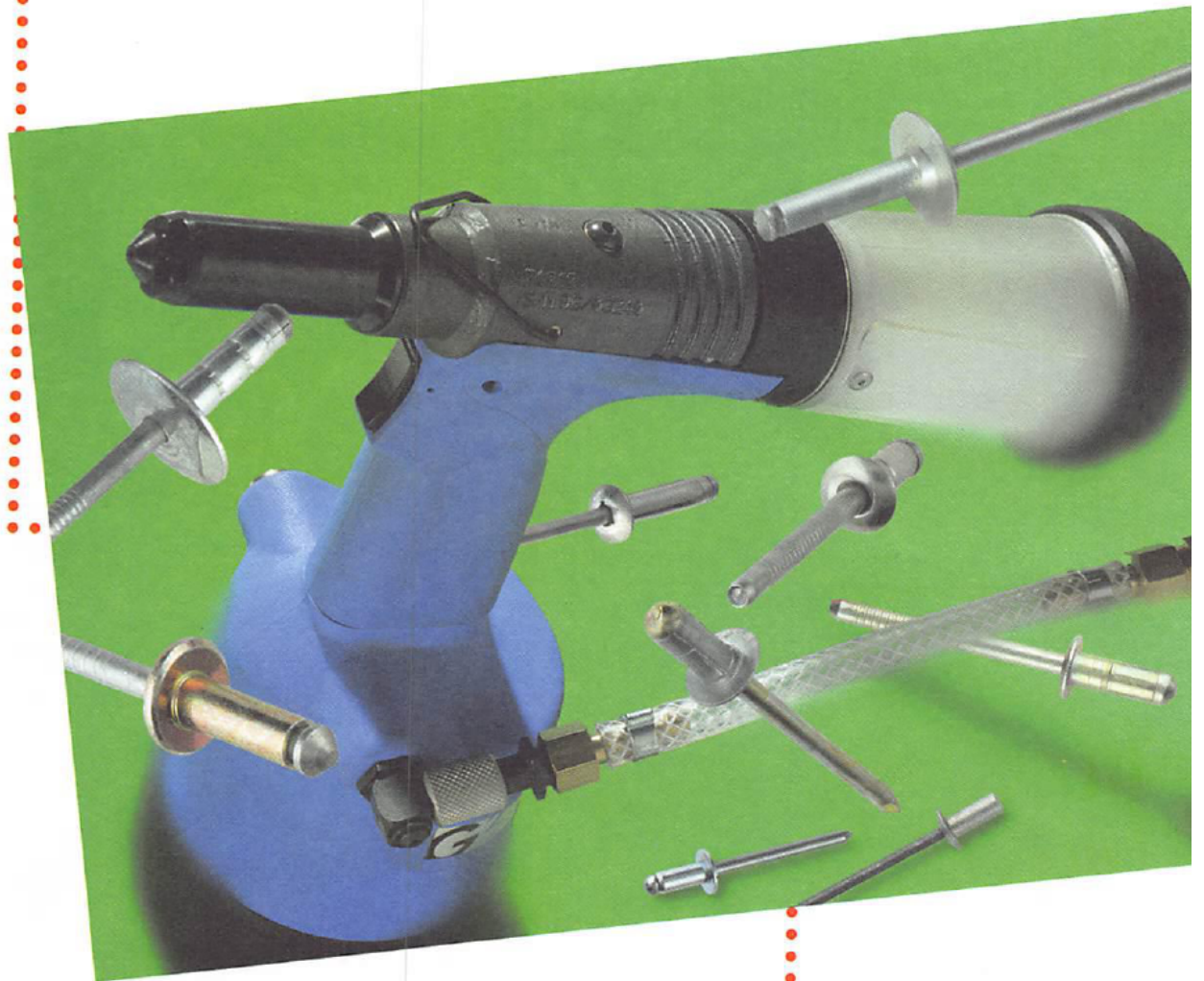


Breakstem Fastening

Engineered Fasteners and Assembly Systems



Avdel Cherry **TEXTRON**



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Warranty Information

Avdel Cherry Textron (hereinafter "Avdel Cherry"), hereby warrants to the initial retail customer and original installer ("Warrantee") only that its products will be free from defects in material and workmanship, provided that the products are used in accordance with Avdel Cherry's instructions as to maintenance, operation and use.

The warrantee's only remedy and Avdel Cherry's only obligation in the event of a defect or failure in the products, is that Avdel Cherry will, at its sole option, repair, replace, or rework the products, but in no case shall the cost of the foregoing exceed the invoice price of the products.

This warranty shall be void if any person seeking to make a claim for defective or failed products fails to notify Avdel Cherry within thirty (30) days of receipt of evidence that the product is defective or has failed, or if said person fails to provide Avdel Cherry with such evidence as is reasonably requested concerning the defect or failure, including without limitation, evidence of the date of purchase and date of installation.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING MERCHANTABILITY OR FITNESS PROVIDED FOR HEREIN. UNDER NO CIRCUMSTANCES SHALL AVDEL CHERRY BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES ARISING FROM ANY DEFECT OR FAILURE IN ITS PRODUCTS.

NOTE: The properties, strengths, dimensions, installed characteristics and all other information in this catalog is for guidance only to aid in the correct selection of the products described herein and is not intended or implied as part of the above warranty. All applications should be evaluated for functional stability and available samples of the described parts can be requested for installed tests, suitability and evaluations

All inquiries concerning this Warranty should be sent to:

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About Avdel Cherry Textron

Avdel Cherry Textron is a 60-year leader in the design and manufacture of quality engineered assembly systems, including structural and non-structural blind rivets, threaded inserts, lockbolts, speed fastening, self-piercing rivets, and installation tools. Avdel Cherry supplies its world class products to the major automakers and their subcontractors, the transportation industry, major electronics manufacturers and their subcontractors, as well as a variety of other industries worldwide.

Avdel Cherry Textron was formed January 1, 1996, following the merger of Cherry Textron's Commercial Fastener Division with the U.S. operating company of UK-based Avdel Textron. Now part of Textron Fastening Systems — the global leader in fastening solutions — Avdel Cherry strengthens the group's international presence that already includes Camcar and Elco in the U.S., together with European-based Avdel Textron, Textron Industries, and Boesner and BSK.

Textron Inc., with annual revenues exceeding \$9 billion (NYSE:TXT), is a global, multi-industry company with market-leading operations in five business segments: Aircraft, Automotive, Industrial, Systems and Components, and Finance. Current and more detailed information regarding Textron Inc. is available by contacting the company's Providence, RI headquarters, or via the Internet: <http://www.textron.com>.

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Breakstem Fastening

General Information

Why Breakstem Rivets?

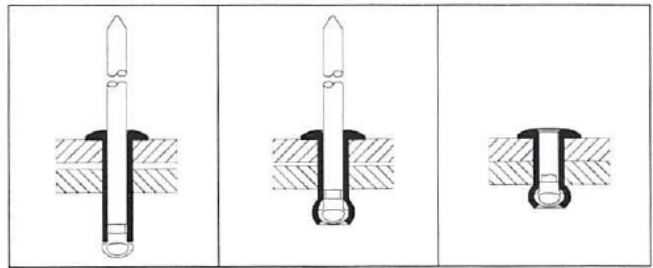
- Low installed cost
- Blind installation
- Permanent, reliable fastening
- Lightweight, ergonomic tooling

Avdel Cherry blind breakstem rivets have been designed to fulfill a variety of functions across a wide range of assembly applications. Labor intensive operations which require access to both sides are made obsolete with Avdel Cherry's breakstem rivet range. The advantages offered by these unique fastening methods are:

1. **Low Installed Cost** The ease of assembly and speed at which the rivets are installed will reduce the final in-place cost of the product manufactured.
2. **Blind Installation** The ability to place Avdel Cherry breakstem rivets from only one side of the workpiece increases the speed and efficiency of the assembly.
3. **Permanent, Reliable Fastening** Blind rivets securely assemble applications and provide a vibration resistant joint. They will not work loose like threaded fasteners.
4. **Lightweight Ergonomic Tooling** Avdel Cherry tooling has been designed with the operator in mind. Torque reliant tooling may cause Carpel Tunnel Syndrome or other repetitive motion injuries.

Installation

The installation of Avdel Cherry blind rivets is easily accomplished with the use of either hand or power riveters. Avdel Cherry manufactures tools from basic handheld tooling to elaborate multihead and/or bowl-fed equipment.



1. The rivet is inserted into the prepared hole.
2. As the stem is pulled by a rivet tool, the blind portion of the rivet expands radially and pulls the application material firmly together.
3. When the rivet is fully expanded, the stem breaks and the installation process is complete.

Selecting the Proper Fastener

1. Select a rivet group that meets the shear and tensile requirements for the application.
2. Select a rivet material that is compatible with the materials being joined. As a general rule the rivet material should have the same physical and mechanical properties as those being joined. Using a dissimilar material may cause joint failure due to either material fatigue or galvanic corrosion.
3. Determine the type of head style required based upon the application material and hole preparation.
4. Measure the thickness of the material to be joined (grip) and prepare the hole for the proper diameter of rivet.

NOTE: Good design practice dictates that a fastener should not be used in applications which fall outside of the specified grip range or recommended hole size.

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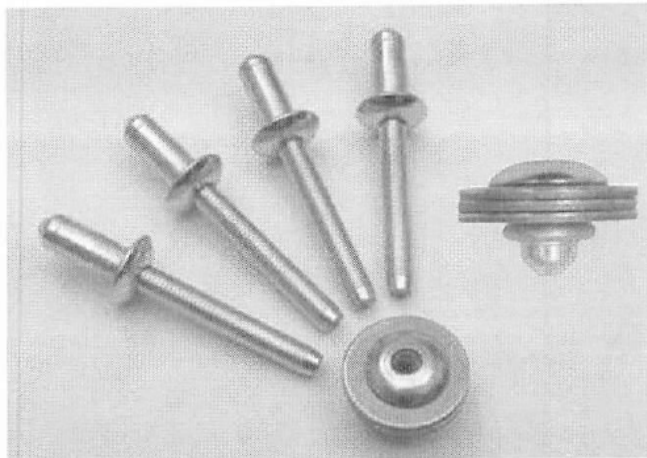
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Avibulb® 1/4" (6.4 mm)

A Steel Blind Rivet with a wide Grip Range

The Avibulb® fastener is a high strength breakstem fastener with excellent bulbing tail formation, which makes it ideal for the use in thin sheet materials. The new 1/4" Avibulb® fastener features a wide grip range, especially suited for applications with varying sheet thicknesses. It is designed for use in applications such as automotive, truck and trailer, white goods and industrial equipment.



Features and Benefits

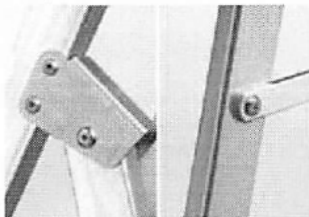
- High shear and tensile strength
- Multi-grip capability
- High residual clamp load
- Resists vibration and joint slippage
- Good blind side footprint and bulb formation
- Spreads the tail bearing load/clamp load on the rear sheet
- Reliable stem retention
- Under head recess accommodates burrs around holes and spreads the load evenly on the top sheet

Installation Tools

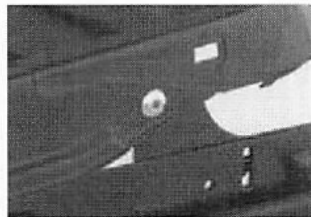
The Avibulb® fastener is installed securely in seconds with the Genesis® nG4 model.

Assembly Applications

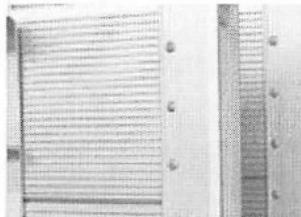
Step ladder



Car seat base



Vehicle panel



Washing machine



Specifications

Part Number	OBN01-00816
Grip range	.059 - .217
Part Number	OBN01-00820
Grip range	.197 - .354
Material	Steel
Surface finish	Zinc, clear passivated
Body diameter	1/4"
Hole diameter	.260 - .276
Shear strength min.	2248 lbf (through stem)
Tensile strength min.	1484 lbf
Stem push-out typical dimensions in inch	450 lbf

For more information please contact your local Avdel representative.

Avdel USA LLC
614 NC Highway 200 South
Stanfield, North Carolina 28163

Avdel Canada, a Division of
Acument Canada Limited
87 Disco Road



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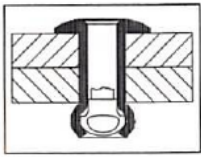
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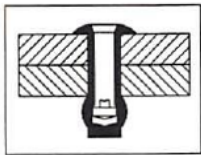
Fastening Systems



N Rivet™

Non-structural blind breakstem rivet designed for a wide range of applications. Available in a variety of materials and combinations with low profile, large flange or countersunk head styles.

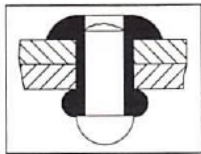
PAGE 6



Closed End Rivet

Blind breakstem sealed body rivet designed to prevent passage of vapor or liquid through the placed fastener. Mandrel will not dislodge into the workpiece.

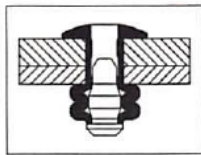
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Avex®

The original multi-grip blind breakstem rivet. Positive stem retention, complete hole fill and wide grip range are some of the unique benefits offered.

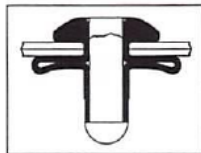
PAGE 12



Stavex®

Multiple grip all-steel breakstem rivet. Unique crimp design provides wide grip range and smooth bubble formation on tailside. Available in low profile, large flange, and countersunk head styles.

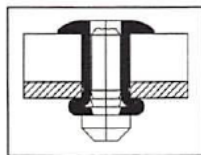
PAGE 16



Bulbex®

All-aluminum corrosion resistant fastener designed for assemblies using soft, brittle, or thin materials. Three petal formation compensates for oversized or irregular holes.

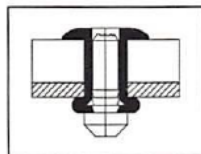
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Avinox® II

All-stainless steel bulbing breakstem rivet. Ideal for use in corrosive or adverse environmental conditions. Good clamp-up provides tight and secure joint without crushing parent material.

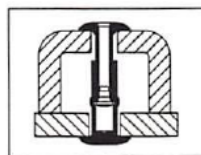
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Avibulb®

All-steel bulbing breakstem rivet. Excellent clamp-up and superior shear and tensile strength result in a vibration resistant joint. Smooth bubble formation is ideal for thin backside material.

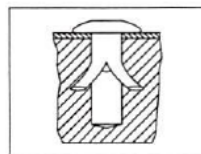
PAGE 22



Cherrymate®

A two piece non-structural fastening system for extra-long grip applications.

PAGE 24



T-Lok®

A cost effective and efficient method of attaching metal to wood, FRP or other soft material without through holes.

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Placement Tools

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Placement Tools Cross Reference Matrix

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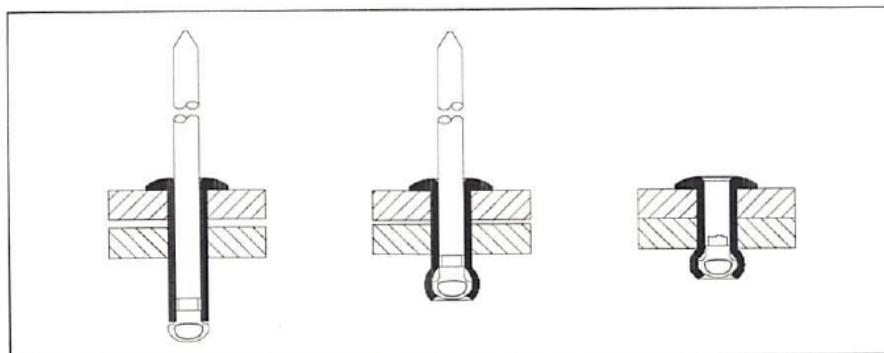
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Non-structural blind breakstem rivet designed for a wide range of applications. Available in a variety of materials and combinations with low profile, large flange or countersunk head styles.



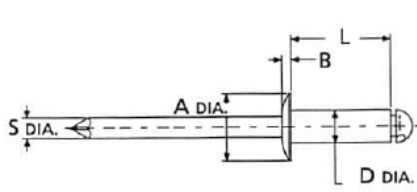
Benefits:

- **Low Cost**
Substantial savings in installed costs can be realized when N Rivet™ fasteners are used in place of spotwelds, adhesives, screws, or bolts.
- **Quick Installation**
When used with manual or hydraulic rivet tools, N Rivet™ fasteners are installed quickly and easily from one side of the workpiece.
- **Increased Mandrel Retention**
The unique design of the mandrel head ensures positive retention after installation.

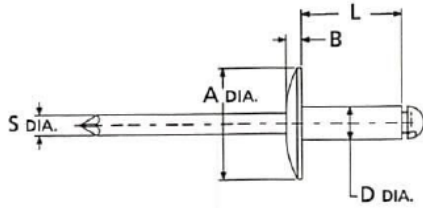


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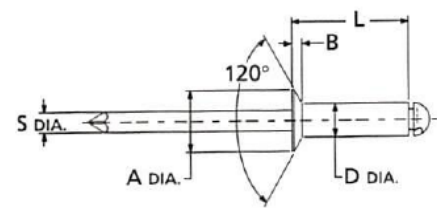
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PROTRUDING HEAD



LARGE FLANGE HEAD



COUNTERSUNK HEAD

Nom. Rivet Diam.	Hole Size	S Nom. Mand. Diam.	D Rivet Diam.	Protruding Head		Large Flange Head		Countersunk Head	
				A Head Diam.	B Max. Head Thick.	A Head Diam.	B Max. Head Thick.	A Head Diam.	B Ref. Head Thick.
3/32" (2,4mm)	.097-.100 (2,46-2,54)	.057 (1,45)	.093 (2,36)	.187 (4,75)	.032 (.81)			.180 (4,57)	.028 (.71)
1/8" (3,2mm)	.129-.133 (3,28-3,38)	.076 (1,93)	.125 (3,18)	.250 (6,35)	.040 (1,02)	.375 (9,53)	.065 (1,65)	.226 (5,74)	.032 (.81)
5/32" (4,0mm)	.160-.164 (4,06-4,17)	.095 (2,41)	.156 (3,96)	.312 (7,92)	.050 (1,27)	.469 (11,92)	.075 (1,91)	.281 (7,14)	.040 (1,02)
3/16" (4,8mm)	.192-.196 (4,88-4,98)	.114 (2,90)	.187 (4,75)	.375 (9,53)	.060 (1,52)	.625 (15,88)	.092 (2,34)	.344 (8,74)	.050 (1,27)
1/4" (6,4mm)	.257-.261 (6,53-6,63)	.151 (3,84)	.250 (6,35)	.500 (12,70)	.080 (2,03)	.750 (19,05)	.107 (2,64)	.468 (11,89)	.071 (1,80)

*L - Length varies with each grip length

Minimum Rivet Shear and Tensile Strength— lb.s.f (N) When tested per IFI 135 Specification 2.1 and 2.2 N RIVET™												
Rivet Diam.	AA Series Alum. Rivet		BS Series Alum. Rivet		SS Series Steel Rivet		MS Series Monel Rivet		CC Series Stainless Rivet		CS Series Stainless Rivet	
	Shear	Tens.	Shear	Tens.	Shear	Tens.	Shear	Tens.	Shear	Tens.	Shear	Tens.
3/32" (2,4mm)	70 (312)	80 (356)	90 (401)	120 (534)	130 (579)	170 (757)	200 (890)	250 (1113)	230 (1024)	280 (1246)	230 (1024)	280 (1246)
1/8" (3,2mm)	120 (534)	150 (668)	170 (757)	220 (979)	260 (1157)	310 (1380)	350 (1558)	450 (2003)	420 (1869)	530 (2359)	420 (1869)	530 (2359)
5/32" (4,0mm)	190 (846)	230 (1024)	260 (1157)	350 (1558)	370 (1647)	470 (2092)	550 (2448)	700 (3115)	650 (2893)	820 (3649)	650 (2893)	820 (3649)
3/16" (4,8mm)	260 (1157)	320 (1424)	380 (1691)	500 (2225)	540 (2403)	680 (3026)	800 (3564)	1000 (4450)	950 (4228)	1200 (5340)	950 (4228)	1200 (5340)
1/4" (6,4mm)	460 (2047)	560 (2492)	700 (3115)	920 (4094)	1000 (4450)	1240 (5518)	1400 (6230)	1850 (8233)	1700 (7565)	2100 (9345)	1700 (7650)	2100 (9345)

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G

Grip is total of material thicknesses

Rivet Diam.	G Rivet Grip Range	L Rivet Length Max.	AA Series Aluminum Rivet, Aluminum Mandrel, IFI 114 Grade 11			BS Series Aluminum Rivet, Steel Mandrel, IFI 114 Grade 19			SS Series Steel Rivet, Plated Steel Mandrel, IFI 114 Grade 30		
			Prot. Head	Large Head	Ctsk. Head	Prot. Head	Large Head	Ctsk. Head	Prot. Head	Large Head	Ctsk. Head
3/32" (2,4mm)	.020-.125 (5,1-3,2)	.250 (6,4)	AAP-03-02		AAC-03-02	BSP-03-02		BSC-03-02	SSP-03-02		SSC-03-02
	.126-.250 (3,2-6,4)	.375 (9,5)	AAP-03-04		AAC-03-04	BSP-03-04		BSC-03-04	SSP-03-04		SSC-03-04
	.251-.375 (6,4-9,5)	.500 (12,7)	AAP-03-06		AAC-03-06	BSP-03-06		BSC-03-06	SSP-03-06		SSC-03-06
1/8" (3,2mm)	Up to .062 (1,6)	.212 (5,4)	AAP-04-01			BSP-04-01			SSP-04-01		
	.063-.125 (1,6-3,2)	.275 (7,0)	AAP-04-02	AAL-04-02	AAC-04-02	BSP-04-02	BSL-04-02	BSC-04-02	SSP-04-02	SSL-04-02	SSC-04-02
	.126-.187 (3,2-4,7)	.337 (8,6)	AAP-04-03		AAC-04-03	BSP-04-03		BSC-04-03	SSP-04-03		SSC-04-03
	.188-.250 (4,8-6,4)	.400 (10,2)	AAP-04-04	AAL-04-04	AAC-04-04	BSP-04-04	BSL-04-04	BSC-04-04	SSP-04-04	SSL-04-04	SSC-04-04
	.251-.312 (6,4-7,9)	.462 (11,7)	AAP-04-05		AAC-04-05	BSP-04-05		BSC-04-05	SSP-04-05		SSC-04-05
	.313-.375 (8,0-9,5)	.535* (13,6)	AAP-04-06	AAL-04-06	AAC-04-06	BSP-04-06	BSL-04-06	BSC-04-06	SSP-04-06	SSL-04-06	SSC-04-06
	.376-.437 (9,6-11,1)	.602* (15,3)	AAP-04-07		AAC-04-07	BSP-04-07		BSC-04-07	SSP-04-07		SSC-04-07
	.438-.500 (11,1-12,7)	.670* (17,0)	AAP-04-08	AAL-04-08	AAC-04-08	BSP-04-08	BSL-04-08	BSC-04-08	SSP-04-08	SSL-04-08	SSC-04-08
	.501-.562 (12,7-14,3)	.738* (18,7)	AAP-04-09		AAC-04-09	BSP-04-09		BSC-04-09	SSP-04-09		SSC-04-09
	.563-.625 (14,3-15,9)	.805* (20,4)	AAP-04-10		AAC-04-10	BSP-04-10		BSC-04-10			
5/32" (4,0mm)	.020-.125 (5,1-3,2)	.300 (7,6)	AAP-05-02			BSP-05-02			SSP-05-02		
	.126-.250 (3,2-6,4)	.425 (10,8)	AAP-05-04	AAL-05-04	AAC-05-04	BSP-05-04	BSL-05-04	BSC-05-04	SSP-05-04	SSL-05-04	SSC-05-04
	.251-.375 (6,4-9,5)	.550 (14,0)	AAP-05-06	AAL-05-06	AAC-05-06	BSP-05-06	BSL-05-06	BSC-05-06	SSP-05-06	SSL-05-06	SSC-05-06
	.376-.500 (9,6-12,7)	.695* (17,7)	AAP-05-08	AAL-05-08	AAC-05-08	BSP-05-08	BSL-05-08	BSC-05-08	SSP-05-08	SSL-05-08	SSC-05-08
	.501-.625 (12,7-15,9)	.830* (21,0)	AAP-05-10		AAC-05-10	BSP-05-10		BSC-05-10	SSP-05-10		SSC-05-10
3/16" (4/8mm)	.020-.125 (5,0-3,2)	.325 (8,3)	AAP-06-02			BSP-06-02			SSP-06-02		
	.126-.250 (3,2-6,4)	.450 (11,4)	AAP-06-04	AAL-06-04	AAC-06-04	BSP-06-04	BSL-06-04	BSC-06-04	SSP-06-04	SSL-06-04	SSC-06-04
	.251-.375 (6,4-9,5)	.575 (14,6)	AAP-06-06	AAL-06-06	AAC-06-06	BSP-06-06	BSL-06-06	BSC-06-06	SSP-06-06	SSL-06-06	SSC-06-06
	.376-.500 (9,6-12,7)	.700 (17,8)	AAP-06-08	AAL-06-08	AAC-06-08	BSP-06-08	BSL-06-08	BSC-06-08	SSP-06-08	SSL-06-08	SSC-06-08
	.501-.625 (12,7-15,9)	.850* (21,6)	AAP-06-10	AAL-06-10	AAC-06-10	BSP-06-10	BSL-06-10	BSC-06-10	SSP-06-10	SSL-06-10	SSC-06-10
	.626-.750 (15,9-19,1)	.980* (24,9)	AAP-06-12	AAL-06-12	AAC-06-12	BSP-06-12	BSL-06-12	BSC-06-12	SSP-06-12	SSL-06-12	SSC-06-12
	.751-.875 (19,1-22,2)	1.11* (28,2)	AAP-06-14	AAL-06-14	AAC-06-14	BSP-06-14	BSL-06-14	BSC-06-14	SSP-06-14	SSL-06-14	SSC-06-14
	.876-1.00 (22,3-25,4)	1.24* (31,5)	AAP-06-16		AAC-06-16	BSP-06-16		BSC-06-16	SSP-06-16		SSC-06-16
1/4 (6,4)	.020-.125 (5,1-3,2)	.375 (9,5)	AAP-08-02			BSP-08-02			SSP-08-02		
	.126-.250 (3,2-6,4)	.500 (12,7)	AAP-08-04	AAL-08-04	AAC-08-04	BSP-08-04	BSL-08-04	BSC-08-04	SSP-08-04	SSL-08-04	SSC-08-04
	.251-.375 (6,4-9,5)	.625 (15,9)	AAP-08-06	AAL-08-06	AAC-08-06	BSP-08-06	BSL-08-06	BSC-08-06	SSP-08-06	SSL-08-06	SSC-08-06
	.376-.500 (9,6-12,7)	.750 (19,1)	AAP-08-08	AAL-08-08	AAC-08-08	BSP-08-08	BSL-08-08	BSC-08-08	SSP-08-08	SSL-08-08	SSC-08-08
	.501-.625 (12,7-15,9)	.900* (22,9)	AAP-08-10	AAL-08-10	AAC-08-10	BSP-08-10	BSL-08-10	BSC-08-10	SSP-08-10	SSL-08-10	SSC-08-10
	.626-.750 (15,9-19,1)	1.03* (26,2)	AAP-08-12	AAL-08-12	AAC-08-12	BSP-08-12	BSL-08-12	BSC-08-12	SSP-08-12	SSL-08-12	SSC-08-12
	.751-.875 (19,1-22,2)	1.16* (29,5)	AAP-08-14	AAL-08-14	AAC-08-14	BSP-08-14	BSL-08-14	BSC-08-14	SSP-08-14	SSL-08-14	SSC-08-14
	.876-1.00 (22,3-25,4)	1.29* (32,8)	AAP-08-16	AAL-08-16	AAC-08-16	BSP-08-16	BSL-08-16	BSC-08-16	SSP-08-16	SSL-08-16	SSC-08-16

*Lengths do not conform to IFI Standards

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Technical Information

N RIVET™ Fastening Systems

IDENTIFICATION CODE:

First letter is rivet material:

A = 5052 Aluminum B = 5056 Aluminum

Second letter is mandrel material:

A = Aluminum S = Steel

Third letter is head style:

P = Protruding L = Large Flange

First number is rivet diameter in 32nds of an inch: For example, 4 is 4/32nds or 1/8" diameter

Second number is rivet maximum grip length in 16ths of an inch: For example, 6 is 6/16ths or 3/8" grip length

C = Stainless M = Monel S = Steel U = Copper

C = Stainless

C = Countersunk

A A P-04-06

MS Series Monel Rivet, Zinc Plated Steel Mandrel, IFI 114 Grade 40			CC Series Stainless Rivet Stainless Mandrel, IFI 114 Grade 51			CS Series Stainless Rivet Steel Mandrel, IFI 114 Grade 50			US Series Copper Rivet Steel Mandrel, IFI 114 Grade 20		
Prot. Head	Large Head	Ctsk. Head	Prot. Head	Large Head	Ctsk. Head	Prot. Head	Large Head	Ctsk. Head	Prot. Head	Large Head	Ctsk. Head
MSP-03-02		MSC-03-02	CCP-03-02		CCC-03-02	CSP-03-02		CSC-03-02			
MSP-03-04		MSC-03-04	CCP-03-04		CCC-03-04	CSP-03-04		CSC-03-04			
MSP-03-06		MSC-03-06									
MSP-04-01			CCP-04-01			CSP-04-01			USP-04-01		
MSP-04-02	MSL-04-02	MSC-04-02	CCP-04-02	CCL-04-02	CCC-04-02	CSP-04-02	CSL-04-02	CSC-04-02	USP-04-02	USL-04-02	USC-04-02
MSP-04-03		MSC-04-03	CCP-04-03		CCC-04-03	CSP-04-03		CSC-04-03	USP-04-03		USC-04-03
MSP-04-04	MSL-04-04	MSC-04-04	CCP-04-04	CCL-04-04	CCC-04-04	CSP-04-04	CSL-04-04	CSC-04-04	USP-04-04	USL-04-04	USC-04-04
MSP-04-05		MSC-04-05	CCP-04-05		CCC-04-05	CSP-04-05		CSC-04-05	USP-04-05		USC-04-05
MSP-04-06	MSL-04-06	MSC-04-06	CCP-04-06	CCL-04-06	CCC-04-06	CSP-04-06	CSL-04-06	CSC-04-06	USP-04-06	USL-04-06	USC-04-06
MSP-04-07		MSC-04-07							USP-04-07		USC-04-07
MSP-04-08		MSC-04-08							USP-04-08	USL-04-08	USC-04-08
									USP-04-09		USC-04-09
									USP-04-10		USC-04-10
MSP-05-02			CCP-05-02			CSP-05-02					
MSP-05-04	MSL-05-04	MSC-05-04	CCP-05-04	CCL-05-04	CCC-05-04	CSP-05-04	CSL-05-04	CSC-05-04			
MSP-05-06	MSL-05-06	MSC-05-06	CCP-05-06	CCL-05-06	CCC-05-06	CSP-05-06	CSL-05-06	CSC-05-06			
MSP-05-08	MSL-05-08	MSC-05-08									
		MSC-05-10									
MSP-06-02			CCP-06-02			CSP-06-02					
MSP-06-04	MSL-06-04	MSC-06-04	CCP-06-04	CCL-06-04	CCC-06-04	CSP-06-04	CSL-06-04	CSC-06-04			
MSP-06-06	MSL-06-06	MSC-06-06	CCP-06-06	CCL-06-06	CCC-06-06	CSP-06-06	CSL-06-06	CSC-06-06			
MSP-06-08	MSL-06-08	MSC-06-08	CCP-06-08	CCL-06-08	CCC-06-08	CSP-06-08	CSL-06-08	CSC-06-08			
MSP-06-10	MSL-06-10	MSC-06-10									
MSP-08-02			CCP-08-02			CSP-08-02					
MSP-08-04		MSC-08-02	CCP-08-04		CCC-08-04	CSP-08-04		CSC-08-04			
MSP-08-06		MSC-08-04	CCP-08-06		CCC-08-06	CSP-08-06		CSC-08-06			
MSP-08-08		MSC-08-06	CCP-08-08		CCC-08-08	CSP-08-08		CSC-08-08			
MSP-08-10		MSC-08-08	CCP-08-10		CCC-08-10	CSP-08-10		CSC-08-10			
MSP-08-12		MSC-08-12									

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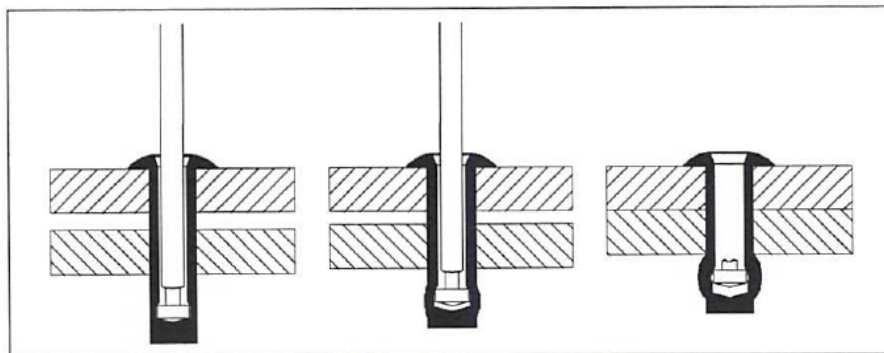


Blind breakstem sealed body rivet designed to prevent passage of vapor or liquid through the placed fastener. Mandrel will not dislodge into the workpiece.



Benefits:

- **Sealed Rivet Body**
Prevents the passage of vapor or liquid through the body of the set rivet.
- **100% Mandrel Retention**
Because the body of the rivet is closed, the mandrel head cannot fall out through the backside into the workpiece.
- **Blind Installation**
Access is required from only one side.



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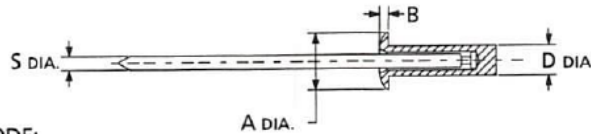
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BSPH-06-04

IDENTIFICATION CODE:

Prefix is rivet style and material

For example, BSPH is aluminum rivet, steel mandrel with a low profile head

First number is rivet diameter in 32nds of an inch.

For example, 6 is 6/32 or 3/16"

Last two digits of suffix denote approximate rivet length to end of body in 32nds of an inch

Series	Head Style	Material		Finish	
		Rivet	Mandrel	Rivet	Mandrel
BSPH	Lo Profile	Aluminum	Steel	Plain	Plain
BAPH*	Lo Profile	Aluminum	Aluminum	Plain	Plain
BSCH*	Countersunk	Aluminum	Steel	Plain	Plain
BCPH*	Lo Profile	Aluminum	Stainless Steel	Plain	Plain
CCPH*	Lo Profile	Stainless Steel	Stainless Steel	Plain	Plain

*Non-standards; contact Customer Service

Nom. Rivet Diam.	Hole Size	S Max. Rivet Diam.	Lo Profile Head	
			B Nom. Head Diam.	D Max. Head Ht.
1/8" (3,2mm)	.130-.134 (3,30-3,40)	.129 (3,28)	.236 (6,00)	.041 (1,05)
5/32" (4,0mm)	.161-.165 (4,10-4,20)	.161 (4,08)	.312 (8,00)	.057 (1,45)
3/16" (4,8mm)	.193-.197 (4,90-5,00)	.192 (4,88)	.375 (9,50)	.065 (1,65)
1/4" (6,4mm)	.256-.264 (6,50-6,70)	.255 (6,48)	.512 (13,00)	.126 (3,20)

Rivet Diam.	Grip Range	L Length Max.	BSPH Series	Typical Strength lbf (N)	
				Shear	Tensile
1/8" (3,2mm)	.032-.062	.296	BSPH-04-01	260 (1160)	353 (1570)
	.063-.125	.355	BSPH-04-02		
	.126-.187	.414	BSPH-04-03		
	.188-.250	.473	BSPH-04-04		
5/32" (4,0mm)	.251-.315	.532	BSPH-04-05	409 (1820)	517 (2300)
	.063-.125	.355	BSPH-05-02		
	.126-.187	.414	BSPH-05-03		
3/16" (4,8mm)	.188-.312	.532	BSPH-05-05	593 (2640)	823 (3660)
	.063-.125	.355	BSPH-06-02		
	.126-.250	.473	BSPH-06-04		
	.251-.375	.591	BSPH-06-06		
1/4" (6,4mm)	.376-.500	.748	BSPH-06-08	900 (4000)	1574 (7000)
	.500-.625	.866	BSPH-06-10		
	.062-.250	.532	BSPH-08-04		
	.251-.375	.670	BSPH-08-06		

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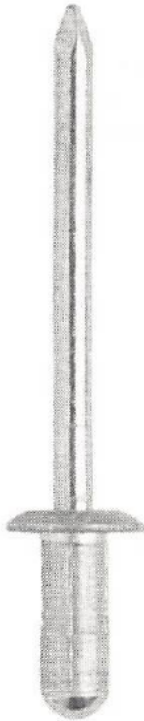
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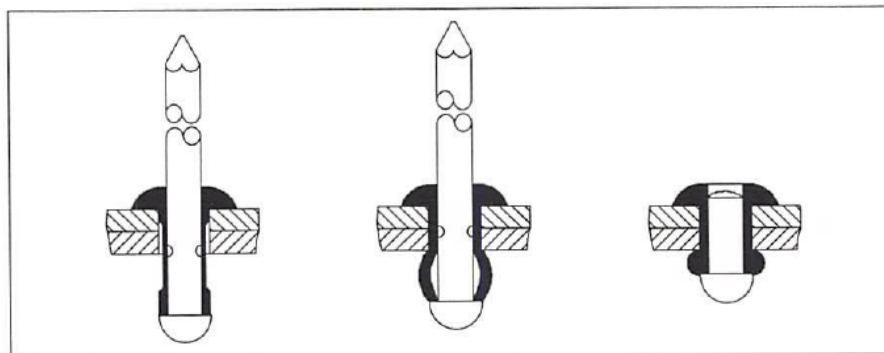
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The original multi-grip blind breakstem rivet. Positive stem retention, complete hole fill and wide grip range are some of the unique benefits offered.



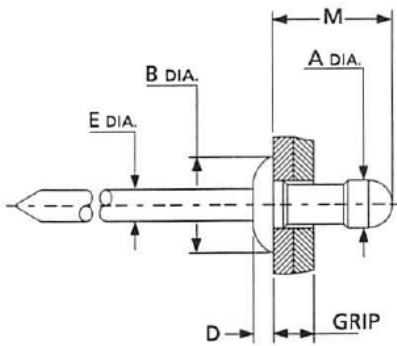
Benefits:

- **Wide Grip Range**
One rivet can be used in multiple material thicknesses. This reduces inventories and eliminates operator error.
- **Mechanically Locked Stem**
Stem is locked in shell, eliminating the risk of mandrel head vibrating loose while providing a weather resistant joint.
- **Complete Hole Fill**
The bulbing formation of the Avex[®] will fill slightly oversized or irregular holes, providing increased strength and vibration resistance.

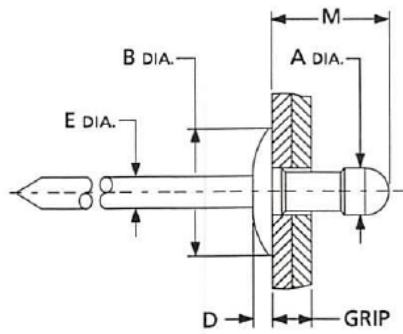


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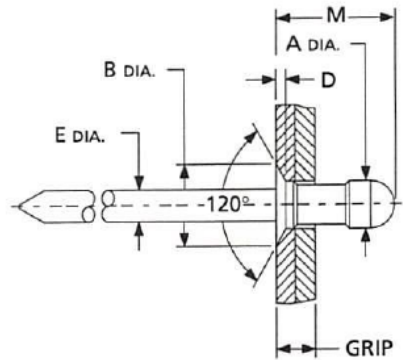
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PROTRUDING HEAD



LARGE FLANGE HEAD



COUNTERSUNK HEAD

Series	Head Style	Material		Finish	
		Rivet	Mandrel	Rivet	Mandrel
1691	Lo Profile	Aluminum	Steel	Plain	Zinc Yellow Dichromate
1692	Large Flange	Aluminum	Steel	Plain	Zinc Yellow Dichromate
1610	Brazier	Aluminum	Steel	Plain	Zinc Yellow Dichromate
1682	Countersunk	Aluminum	Steel	Plain	Zinc Yellow Dichromate
1624	Lo Profile	Steel	Steel	Zinc Plated	Zinc Coated

* 1610-4506 is same parameter as Series 1691

Nom. Rivet Diam.	Hole Size	E Max.	A Rivet Diam.	Lo-Profile Head		Lrg-Flange Head		Brazier Head		CSK Head		Series 1624 Steel AVEX®	
				B Nom. Head Diam.	D Max. Head Ht.	B Nom. Head Diam.	D Max. Head Ht.	B Nom. Head Diam.	D Max. Head Ht.	B Nom. Head Diam.	D Max. Head Ht.	B Nom. Head Diam.	D Max. Head Ht.
1/8" (3,2mm)	.128-.133 (3,25-3,38)	.074 (1,87)	.120-.125 (3,06-3,17)	.252 (6,40)	.051 (1,30)	.325 (8,25)	.045 (1,14)			.207 (5,27)	.050 (1,27)	.285 (7,22)	.047 (1,19)
5/32" (4,0mm)	.161-.166 (4,09-4,22)	.090 (2,27)	.155-.160 (3,95-4,06)	.311 (7,90)	.061 (1,55)	.375 (9,52)	.058 (1,47)			.247 (6,28)	.052 (1,32)	.320 (8,13)	.062 (1,57)
3/16" (4,8mm)	.194-.199 (4,93-5,05)	.112 (2,83)	.185-.190 (4,71-4,83)	.387 (9,80)	.071 (1,80)	.625 (15,88)	.075 (1,90)	.472 (12,00)	.098 (2,49)	.347 (8,81)	.069 (1,75)	.385 (9,78)	.084 (2,13)
1/4" (6,3mm)	.261-.275 (6,63-6,99)	.158 (4,01)	.250-.260 (6,35-6,60)	.515 (13,1)	.105 (2,67)								

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Countersunk Head Styles				
Rivet Diam.	G Grip Range	M Length Max.	Series 1682 Alum. Rivet Steel Mandrel	Series 1667 Alum. Rivet St. Steel Mandrel
1/8" (3,2mm)	.093-.250 (2,36-6,35)	.470 (11,94)	1682-0412	
	.155-.312 (3,94-7,92)	.530 (13,46)	1682-0414	
	.217-.375 (5,51-9,53)	.600 (15,24)	1682-0416	
5/32" (4,0mm)	.109-.312 (2,77-7,92)	.550 (13,97)	1682-0514	
	.171-.375 (4,34-9,53)	.610 (15,49)	1682-0516	
3/16" (4,8mm)	.125-.312 (3,18-7,72)	.610 (15,49)	1682-0615	
	.250-.500 (6,35-12,7)	.800 (20,32)	1682-0621	1667-0621

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Low Profile/Large Flange Head Styles							Brazier Head
Rivet Diam.	G Grip Range	M Length Max.	Series 1691/1610 Alum. Rivet Steel Mandrel	Series 1692 Alum. Rivet Steel Mandrel	Series 1663 Alum. Rivet St. Steel Mandrel	Series 1643 Alum. Rivet St. Steel Mandrel	Series 1610 Alum. Rivet Steel Mandrel
1/8" (3,2mm)	.031-.187 (,790-4,75)	.410 (10,41)	1691-0410	1692-0410			
	.125-.312 (3,10-7,92)	.530 (13,46)	1691-0414	1692-0414			
	.187-.375 (4,75-9,53)	.590 (14,99)	1691-0416				
5/32" (4,0mm)	.046-.250 (1,17-6,35)	.480 (12,19)	1691-0512				
	.125-.312 (3,18-7,92)	.540 (13,72)	1691-0514	1692-0514			
3/16" (4,8mm)	.156-.375 (4,00-9,53)	.610 (15,49)	1691-0516				
	.062-.250 (1,57-6,35)	.550 (13,97)	1691-0613	1692-0613	1663-0613	1643-0613	1610-3722
	.187-.437 (4,75-11,10)	.730 (18,54)	1691-0619		1663-0619		1610-3716
	.250-.500 (6,35-12,70)	.780 (19,81)	1691-0621	1692-0621	1663-0621	1643-0621	
1/4" (6,5mm)	.500-.781 (12,70-19,84)	1.09 (27,69)	1691-0631	1692-0631	1663-0631	1643-0631	
	.080-.325 (2,03-8,26)	.660 (16,76)	1610-4506				

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1691-06-13

IDENTIFICATION CODE:

Prefix is rivet style and material

For example, 1691 is aluminum rivet, steel mandrel with a low profile head

First two digits of suffix denote diameter in 32nds of an inch

For example, 06 is 3/16" diameter

Last two digits of suffix denote approximate rivet length to end of body in 32nds of an inch

Steel AVEX®			
Rivet Diam.	G Grip Range	M Length Max.	Series 1624 Steel Rivet Steel Mandrel
1/8" (3,2mm)	.044-.156 (1,10-4,00)	.450 (11,40)	1624-0411
5/32" (4,0mm)	.056-.196 (1,40-5,00)	.540 (13,60)	1624-0514
3/16" (4,8mm)	.047-.187 (1,20-4,80)	.550 (13,80)	1624-0612
	.156-.250 (4,00-6,30)	.640 (16,20)	1624-0616

Typical Rivet Shear and Tensile Strength—lbf (N) AVEX®								
Rivet Diam.	Series 1691/1692 Aluminum		Series 1610 Aluminum		Series 1682 Aluminum		Series 1624 Steel	
	Shear	Tens.	Shear	Tens.	Shear	Tens.	Shear	Tens.
1/8" (3.2mm)	165 (735)	230 (1025)			155 (690)	205 (910)	300 (1334)	385 (1710)
5/32" (4.0mm)	255 (1135)	375 (1670)			225 (1000)	300 (1335)	440 (1955)	530 (2355)
3/16" (4.8mm)	350 (1535)	530 (2335)	340 (1512)	505 (2246)	350 (1555)	530 (2355)	1624-0612 810 (3605)	750 (3335)
							1624-0616 1025 (4560)	780 (3470)
1/4" (6.5mm)	Stem in Shear Plane 700 (3110)	Stem Outside Plane 400 (1780)	560 (2490)					

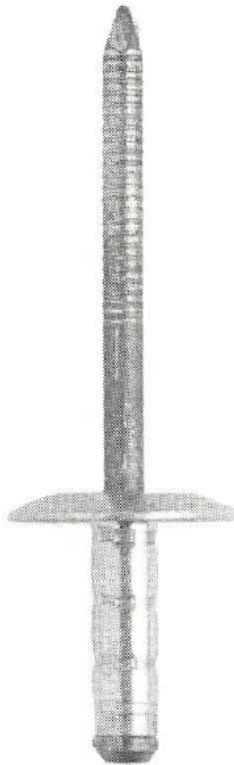
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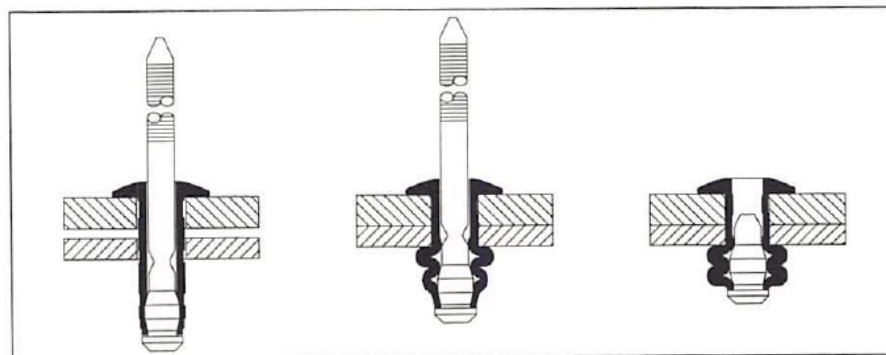


Multiple grip all-steel breakstem rivet. Unique crimp design provides wide grip range and smooth bubble formation on tailside. Available in low profile, large flange, and countersunk head styles.



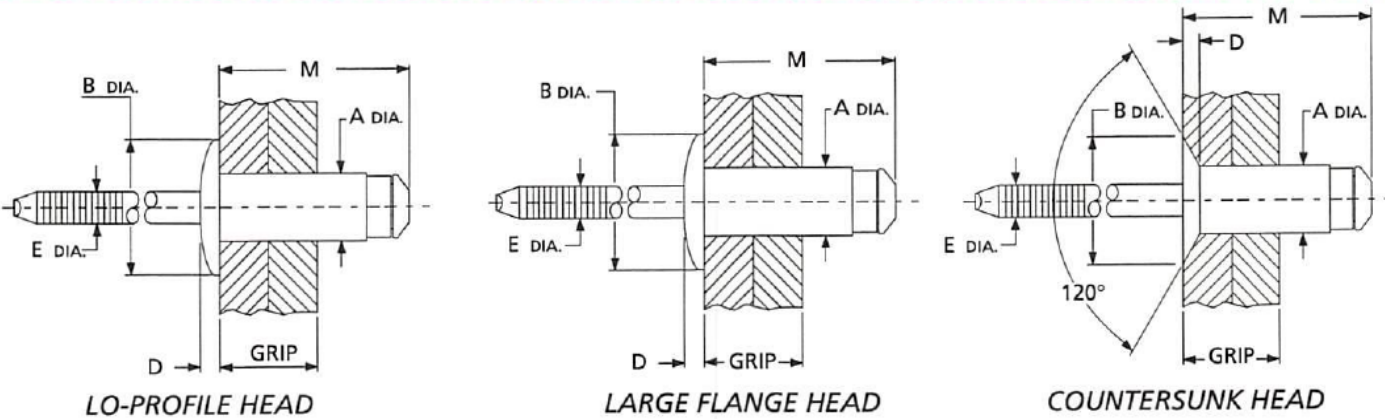
Benefits:

- **Wide Grip Range**
One rivet can be used in multiple material thicknesses, a very unique feature for an all-steel breakstem rivet.
- **Mechanically Locked Stem**
Stem is locked in shell, eliminating the risk of mandrel head vibrating loose while providing a weather resistant joint.
- **Complete Hole Fill**
The bulbing formation of the Stavax[®] will fill slightly oversized or irregular holes, providing increased strength and vibration resistance.



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IDENTIFICATION CODE:

Prefix is rivet style and material

For example, BS01 is steel Stavex with a low profile head

First two digits of suffix denote diameter in 32nds of an inch

Last two digits of suffix denote approximate rivet length to end of body in 32nds of an inch

BS01-06-18

Series	Head Style	Material		Finish	
		Rivet	Mandrel	Rivet	Mandrel
BS01	Lo Profile	Carbon Steel	Carbon Steel	Zinc	Zinc or Phosphate
BE34	Large Flange	Carbon Steel	Carbon Steel	Zinc	Zinc
BS04	Countersunk	Carbon Steel	Carbon Steel	Zinc	Zinc

Nom. Rivet Diam.	Hole Size	E Max.	A Rivet Diam.	Lo-Profile Head		Large-Flange Head		Countersunk Head	
				B Nom. Head Diam.	D Max. Head Ht.	B Nom. Head Diam.	D Max. Head Ht.	B Nom. Head Diam.	D Max. Head Ht.
3/16" (4,8mm)	.192-.196 (4,88-4,98)	.118 (3,00)	.183-.187 (4,65-4,75)	.387 (9,80)	.061 (1,55)	.621 (15,77)	.081 (2,06)	.347 (8,81)	.055 (1,40)
1/4" (6,3mm)	.261-.275 (6,63-6,99)	.158 (4,01)	.250-.260 (6,35-6,60)	.515 (13,1)	.105 (2,67)				

Rivet Diam.	G Grip Range	M Length Max.	Series BS01 Steel Rivet Steel Mandrel	Series BE34 Steel Rivet Steel Mandrel	Series BS04 Steel Rivet Steel Mandrel
3/16" (4,8mm)	.060-.250 (1,52-6,35)	.540 (13,72)	BS01-0614	BE34-0614	BS04-0614
	.060-.375 (1,52-9,52)	.670 (17,02)	BS01-0618	BE34-0618	BS04-0618
	.250-.500 (6,35-12,7-0)	.790 (20,07)	BS01-0622	BE34-0622	BS04-0622
1/4" (6,3mm)	.060-.300 (1,52-7,62)	.660 (16,76)	1610-4844		

Rivet Diam.	STAVEX® Strength Values—lbf (N)				
	1610-4844 Steel		Series BS01/BS04/BE34 Steel		
	Shear	Tens.	Shear	Tens.	Tens.
3/16" (4,8mm)			Stem in Shear Plane 950 (4230)	Stem Outside Plane 450 (2000)	650 (2890)
1/4" (6,3mm)	Stem in Shear Plane 1500 (6670)	Stem Outside Plane 700 (3110)	800 (3560)		

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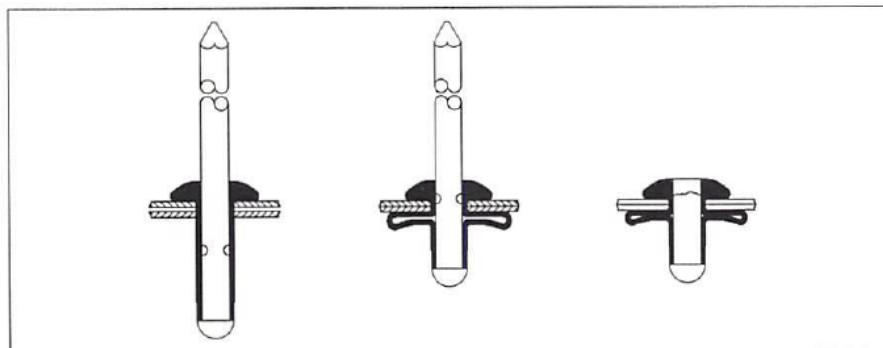
All-aluminum corrosion resistant fastener designed for assemblies using soft, brittle, or thin materials. Three petal formation compensates for oversized or irregular holes.

Benefits:

- **Three-petal Formation on Blind Side**
Eliminates the risk of cracking or crazing parent material. Compensates for oversized or irregular holes.
- **Wide Grip Range**
One rivet can be used in multiple material thicknesses. This reduces inventories and eliminates operator error.
- **All-Aluminum Construction**
Corrosion resistant and lightweight fastener.



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Bulbex is a



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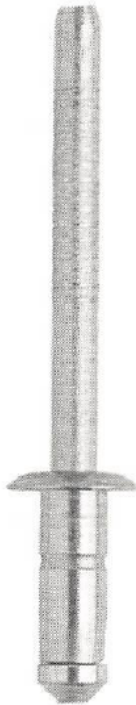
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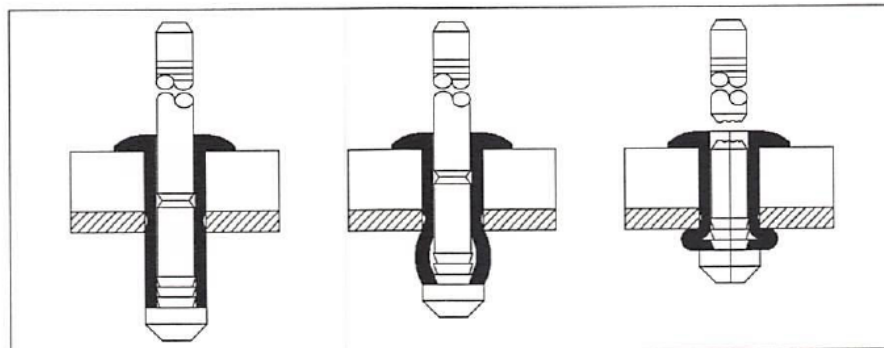
Jan. 97

All-stainless steel bulbing breakstem rivet. Ideal for use in corrosive or adverse environmental conditions. Good clamp-up provides tight and secure joint without crushing parent material.



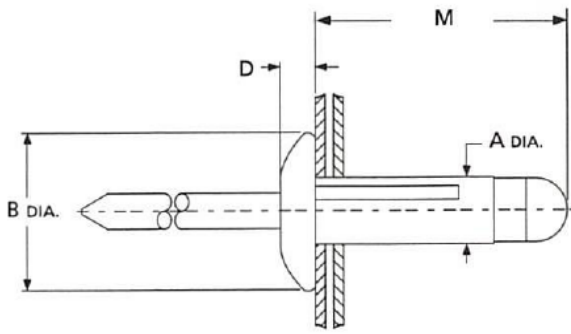
Benefits:

- **All-Stainless Steel**
For use in corrosive or adverse environmental conditions.
- **Bulbing Tail Formation**
Large bearing surface is ideal when thin backside material is part of the assembly. Pull-out is increased and thin material is not deformed.
- **Positively Locked Stem**
High clamp-up and positive stem retention ensures a vibration resistant joint.

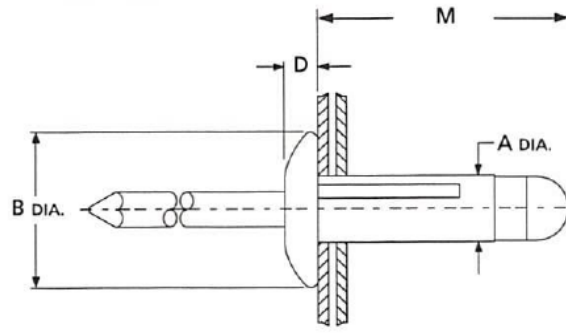


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LO-PROFILE HEAD



LARGE FLANGE HEAD

IDENTIFICATION CODE:

Prefix is rivet style and material

For example, BFO1 is aluminum Bulbex with a low profile head

First two digits of suffix denote diameter in 32nds of an inch

Last two digits of suffix denote approximate rivet length to end of body in 32nds of an inch

BFO1-06-25

Series	Head Style	Material		Finish	
		Rivet	Mandrel	Rivet	Mandrel
BFO1	Lo Profile	Aluminum	Aluminum	Plain	Plain
BF41	Large Flange	Aluminum	Aluminum	Plain	Plain

Nom. Rivet Diam.	Hole Size	E Max.	Lo-Profile Head			Large-Flange Head	
			A Max. Rivet Diam.	B Nom. Head Diam.	D Max. Head Ht.	B Nom. Head Diam.	D Max. Head Ht.
5/32" (4,0mm)	.165-.177 (4,20-4,50)	.090 (2,27)	.165 (4,19)	.312 (7,90)	.060 (1,53)		
3/16" (4,8mm)	.197-.207 (5,00-5,25)	.112 (2,83)	.197 (5,00)	.387 (9,83)	.080 (2,04)	.610 (15,50)	.080 (2,04)

Rivet Diam.	Grip Range	M Max.	Series BFO1 Aluminum Rivet Aluminum Mandrel	Series BF41 Aluminum Rivet Aluminum Mandrel
5/32" (4,0mm)	.040-.118 (1,00-3,00)	.630 (16,00)	BFO1-0516	
	.040-.275 (1,00-7,50)	.840 (21,20)	BFO1-0523	
3/16" (4,8mm)	.040-.157 (1,00-4,00)	.720 (18,30)	BFO1-0619	BF41-0619
	.040-.354 (1,00-9,00)	.920 (23,30)	BFO1-0625	BF41-0625
	.157-.472 (4,00-12,00)	1.07 (27,10)	BFO1-0630	

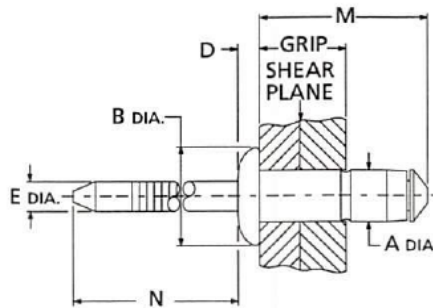
Typical Rivet Shear and Tensile Strength lbf (N) BULBEX®		
Rivet Diam. 5/32	BFO1/BF41 Aluminum	
	Shear	Tens.
5/32" (4,8mm)	135 (600)	225 (1000)
3/16" (6,3mm)	175 (780)	240 (1070)

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BE61-06-14

IDENTIFICATION CODE:

Prefix is rivet style and material

For example, BE61 is stainless steel Avinox II with a low profile head

First two digits of suffix denote diameter in 32nds of an inch

Last two digits of suffix denote approximate rivet length to end of body in 32nds of an inch

Series	Head Style	Material		Finish	
		Rivet	Mandrel	Rivet	Mandrel
BE61	LO PROFILE	Stainless Steel	Stainless Steel	Natural	Natural

Nom. Rivet Diam.	Hole Size	E Max.	A Rivet Diam.	Lo-Profile Head	
				B Nom. Head Diam.	D Max. Head Height
1/8" (3,2mm)	.130-.134 (3,30-3,40)	.083 (2,10)	.122-.130 (3,10-3,30)	.248 (6,30)	.043 (1,10)
5/32" (4,0mm)	.161-.169 (4,10-4,30)	.102 (2,60)	.153-.160 (3,90-4,06)	.303 (7,70)	.059 (1,50)
3/16" (4,8mm)	.193-.201 (4,90-5,10)	.126 (3,20)	.183-.191 (4,65-4,85)	.366 (9,30)	

Rivet Diam.	G Grip Range	M Length Max.	Series BE61 St. Steel Rivet St. Steel Mandrel
1/8" (3,2mm)	.039-.118 (1,0-3,0)	.350 (8,90)	BE61-0408
	.118-.197 (3,0-5,0)	.450 (11,40)	BE61-0411
	.197-.276 (5,0-7,0)	.540 (13,60)	BE61-0414
5/32" (4,0mm)	.039-.118 (1,0-3,0)	.400 (7,50)	BE61-0509
	.118-.197 (3,0-5,0)	.480 (12,10)	BE61-0512
	.197-.276 (5,0-7,0)	.600 (15,10)	BE61-0516
3/16" (4,8mm)	.059-.138 (1,5-3,5)	.510 (12,90)	BE61-0611
	.138-.236 (3,5-6,0)	.610 (15,50)	BE61-0614
	.236-.335 (6,0-8,5)	.730 (18,50)	BE61-0618

Typical Rivet Shear and Tensile Strength lbf (N) AVINOX® II Series BE61 Stainless Steel				
Rivet Diam.	Part No.	Shear		Tensile
		Stem in Shear Plane	Stem not in Shear Plane	
1/8" (3,2mm)	BE61-0408	360 (1600)	360 (1600)	450 (2000)
	BE61-0411	382 (1700)	360 (1600)	
	BE61-0414	719 (3200)	360 (1600)	
5/32" (4,0mm)	ALL	1169 (5200)	629 (2800)	899 (4000)
3/16" (4,8mm)	ALL	1236 (5500)	877 (3900)	1124 (5000)

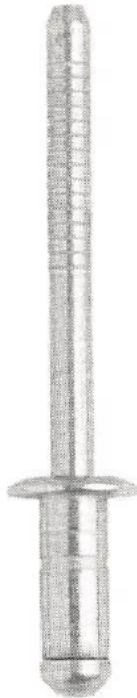
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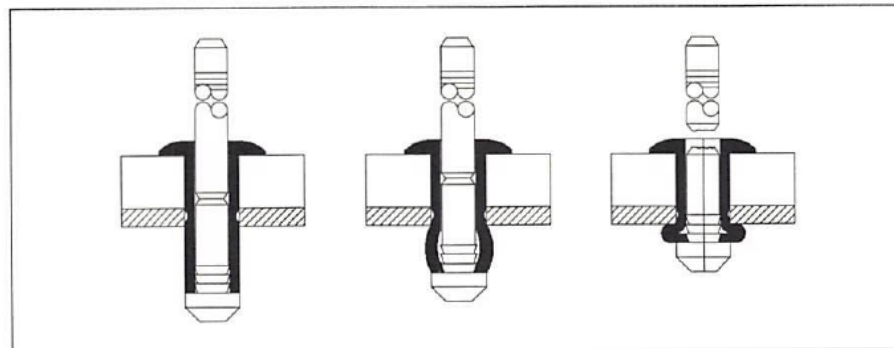


All-steel bulbing breakstem rivet. Excellent clamp-up and superior shear and tensile strength result in a vibration resistant joint. Smooth bubble formation is ideal for thin backside material.



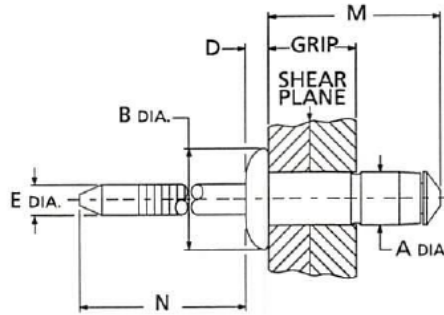
Benefits:

- **All-Steel Construction**
Provides extremely high shear and tensile strengths.
- **Bulbing Tail Formation**
Large bearing surface is ideal when thin backside material is part of the assembly. Pull-out is increased and thin material is not deformed.
- **Positively Locked Stem**
High clamp-up and positive stem retention ensures a vibration resistant joint.



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IDENTIFICATION CODE:

Prefix is rivet style and material

For example, BN01 is steel Avibulb with a low profile head

First two digits of suffix denote diameter in 32nds of an inch

Last two digits of suffix denote approximate rivet length to end of body in 32nds of an inch

BN01-06-14

Series	Head Style	Material		Finish	
		Rivet	Mandrel	Rivet	Mandrel
BN01	Lo Profile	Steel	Steel	Zinc Yellow Dichromate	Zinc Yellow Dichromate

Nom. Rivet Diam.	Hole Size	E Max.	A Rivet Diam.	Lo-Profile Head	
				B Nom. Head Diam.	D Max. Head Height
1/8" (3,2mm)	.130-.134 (3,30-3,40)	.083 (2,10)	.122-.130 (3,10-3,30)	.248 (6,30)	.055 (1,40)
5/32" (4,0mm)	.161-.169 (4,10-4,30)	.102 (2,60)	.153-.160 (3,90-4,06)	.303 (7,70)	.059 (1,50)
3/16" (4,8mm)	.193-.201 (4,90-5,10)	.126 (3,20)	.185-.192 (4,70-4,87)	.366 (9,30)	.059 (1,50)

Rivet Diam.	G Grip Range	M Length Max.	Series BN01 Steel Rivet Steel Mandrel
1/8" (3,2mm)	.039-.118 (1,0-3,0)	.343 (8,70)	BN01-0408
	.118-.197 (3,0-5,0)	.445 (11,30)	BN01-0411
	.197-.276 (5,0-7,0)	.535 (13,60)	BN01-0414
5/32" (4,0mm)	.039-.118 (1,0-3,0)	.400 (7,50)	BN01-0509
	.118-.197 (3,0-5,0)	.480 (12,10)	BN01-0512
	.197-.276 (5,0-7,0)	.600 (15,10)	BN01-0516
3/16" (4,8mm)	.059-.138 (1,5-3,5)	.480 (12,10)	BN01-0611
	.138-.236 (3,5-6,0)	.580 (14,60)	BN01-0614
	.236-.335 (6,0-8,5)	.700 (17,60)	BN01-0618

Typical Rivet Shear and Tensile Strength lbf (N)				
AVIBULB®				
Series BN01 Steel				
Rivet Diam.	Part No.	Shear		Tensile
		Stem in Shear Plane	Stem not in Shear Plane	
1/8" (3,2mm)	BN01-0408	270 (1200)	N/A	310 (1380)
	BN01-0411	393 (1750)		
	BN01-0414	562 (2500)		
5/32" (4,0mm)	BN01-0509	539 (2400)	416 (1850)	629 (2800)
	BN01-0512	787 (3500)		
	BN01-0516	921 (4100)		
3/16" (4,8mm)	BN01-0611	809 (3600)	742 (3300)	854 (3800)
	BN01-0614	944 (4200)		
	BN01-0618	1258 (5600)		

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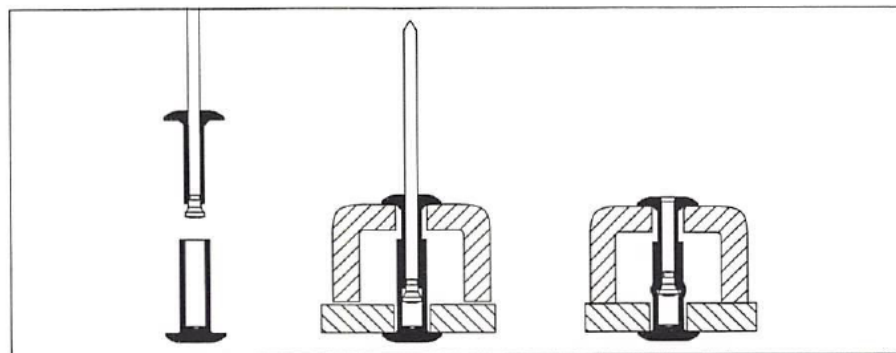
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A two-piece non-structural fastening system for extra-long grip applications.



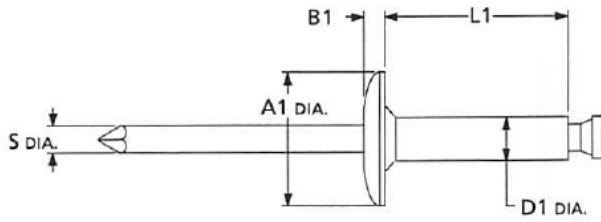
Benefits

- **Extra Wide Grip Range**
Can be used in thicknesses up to nearly 4".
- **Controlled Clamp Up**
Clamps tightly and securely without crushing parent material.
- **Non-Critical Holes**
Not necessary to have close-tolerance hole preparation.

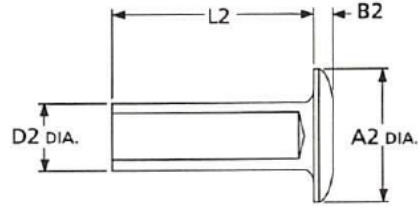


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BLIND RIVET



TUBULAR COMPONENT

Nom. Rivet Diam.	Hole Size and Drill Number	Blind Rivet				Tubular Comp.		
		S Mand. Diam.	D1 Rivet Diam.	A1 Head Diam.	B1 Head Thick.	D1 Rivet Diam.	A1 Head Diam.	B1 Head Thick.
3/16" (4,8mm)	.250 (6,4)	.076 (1,9)	.125 (3,2)	.375 (9,5)	.059 (1,5)	.188 (4,8)	.375 (9,5)	.057 (1,4)
1/4" (6,4mm)	.312 (7,9)	.114 (2,9)	.187 (4,8)	.625 (15,9)	.095 (2,4)	.250 (6,4)	.625 (15,9)	.095 (2,4)

Rivet Diam.	G Rivet Grip Range	L1 Rivet Length (Max.)	L2 Comp. Length (Max.)	Blind Rivet Alum. Sleeve Alum. Mandrel Tubular Comp. Aluminum	Blind Rivet Steel Sleeve Plated Steel Mandrel Plated Tubular Comp. Steel Plated	Blind Rivet Alum. Sleeve Steel Mandrel Plated Tubular Comp. Aluminum
3/16" (4,8mm)	5/8 to 3/4	.525 (13,3)	.585 (14,9)	BALM-6BP-12	SSLM-6SP-12	BSLM-6BP-12
	11/16 to 7/8	.525 (13,3)	.647 (16,4)	BALM-6BP-14	SSLM-6SP-14	BSLM-6BP-14
	7/8 to 1-1/16	.525 (13,3)	.825 (21,0)	BALM-6BP-17	SSLM-6SP-17	BSLM-6BP-17
	1-1/16 to 1-1/4	.525 (13,3)	1.012 (25,7)	BALM-6BP-20	SSLM-6SP-20	BSLM-6BP-20
	1-1/4 to 1-7/16	.525 (13,3)	1.200 (30,5)	BALM-6BP-23	SSLM-6SP-23	BSLM-6BP-23
	1-7/16 to 1-5/8	.525 (13,3)	1.387 (35,2)	BALM-6BP-26	SSLM-6SP-26	BSLM-6BP-26
	1-5/8 to 1-13/16	.525 (13,3)	1.575 (40,0)	BALM-6BP-29	SSLM-6SP-29	BSLM-6BP-29
	1-13/16 to 2	.525 (13,3)	1.762 (44,8)	BALM-6BP-32	SSLM-6SP-32	BSLM-6BP-32
	2 to 2-3/16	.525 (13,3)	1.950 (49,5)	BALM-6BP-35	SSLM-6SP-35	BSLM-6BP-35
2-3/16 to 2-3/8	.525 (13,3)	2.137 (54,3)	BALM-6BP-38	SSLM-6SP-38	BSLM-6BP-38	

Typical Tension Values—Not Available

1/4" (6,4)	5/8" to 3/4	.454 (11,5)	.580 (14,7)	BALM-8BP-12	SSLM-8SP-12	BSLM-8BP-12
	3/4 to 7/8	.608 (15,4)	.695 (17,7)	BALM-8BP-14	SSLM-8SP-14	BSLM-8BP-14
	7/8 to 1-1/8	.608 (15,4)	.820 (20,8)	BALM-8BP-18	SSLM-8SP-18	BSLM-8BP-18
	1-1/8 to 1-3/8	.608 (15,4)	1.070 (27,2)	BALM-8BP-22	SSLM-8SP-22	BSLM-8BP-22
	1-3/8 to 1-5/8	.608 (15,4)	1.320 (33,5)	BALM-8BP-26	SSLM-8SP-26	BSLM-8BP-26
	1-5/8 to 1-7/8	.608 (15,4)	1.570 (39,9)	BALM-8BP-30	SSLM-8SP-30	BSLM-8BP-30
	1-7/8 to 2-1/8	.608 (15,4)	1.820 (46,2)	BALM-8BP-34	SSLM-8SP-34	BSLM-8BP-34
	2-1/8 to 2-3/8	.608 (15,4)	2.070 (52,6)	BALM-8BP-38	SSLM-8SP-38	BSLM-8BP-38
	2-3/8 to 2-5/8	.608 (15,4)	2.320 (58,9)	BALM-8BP-42	SSLM-8SP-42	BSLM-8BP-42
	2-5/8 to 2-7/8	.608 (15,4)	2.570 (65,3)	BALM-8BP-46	SSLM-8SP-46	BSLM-8BP-46
	2-7/8 to 3-1/8	.608 (15,4)	2.820 (71,6)	BALM-8BP-50	SSLM-8SP-50	BSLM-8BP-50
	3-1/8 to 3-3/8	.608 (15,4)	3.070 (78,0)	BALM-8BP-54	SSLM-8SP-54	BSLM-8BP-54
	3-3/8 to 3-5/8	.608 (15,4)	3.320 (84,3)	BALM-8BP-58	SSLM-8SP-58	BSLM-8BP-58
3-5/8 to 3-7/8	.608 (15,4)	3.570 (90,7)	BALM-8BP-62	SSLM-8SP-62	BSLM-8BP-62	
Typical Tensile Value				250 lbs.	350 lbs.	450 lbs.

NOTE: This table reflects typical results in test parameters.

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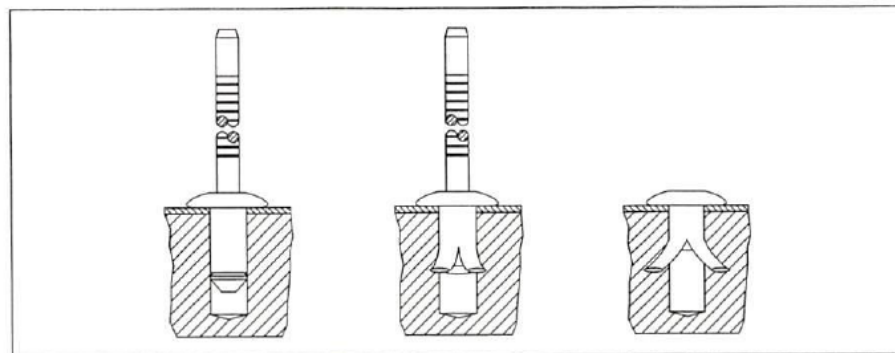


A cost-effective and efficient method of attaching metal to wood, FRP or other soft material without through holes.



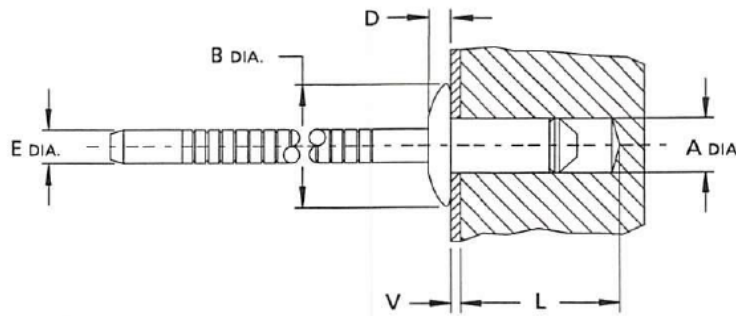
Benefits:

- **Vibration Resistant**
Ideal replacement for wood or self-tapping screws.
- **Large Bearing Surface Expands into Blind Hole**
Superior pull-out force.
- **Quick, One-Sided Installation**
Installed easily with conventional breakstem rivet tooling.



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BM01-06-14

IDENTIFICATION CODE:

Prefix is rivet style and material

For example, BM01 is steel T-Lok with a low profile head

First two digits of suffix denote diameter in 32nds of an inch

Last two digits of suffix denote approximate rivet length to end of body in 32nds of an inch

Series	Head Style	Material		Finish	
		Rivet	Mandrel	Rivet	Mandrel
BM01	Lo Profile	Low Carbon Steel	Low Carbon Steel	Zinc Plated Yellow Chromate	Zinc Coated
BM04	Lo Profile	Low Carbon Steel	Low Carbon Steel	Zinc Plated Clear Chromate	Zinc Coated

Nom. Rivet Diam.	Hole Size	E Max.	A Rivet Diam.	Lo-Profile Head	
				B Nom. Head Diam.	D Max. Head Height
5/32" (4,3mm)	.169-.174 (4,30-4,42)	.099 (2,52)	.162-.169 (4,12-4,29)	.311 (7,90)	.051 (1,30)
3/16" (4,8mm)	.187-.193 (4,76-4,89)	.114 (2,89)	.178-.187 (4,52-4,74)	.394 (10,00)	.081 (2,03)

T-LOK® Series BM01/BM04 Steel lbf (N)							
Rivet Diam.	Rivet Part No.	V		L min.		'M' Max.	Typical Pull-Out Strength
		Min.	Max.	For 'V' Min.	For 'V' Max.		
5/32" (4,3mm)	Prefix -0512	.010 (,250)	.050 (1,27)	.400 (10,20)	.360 (9,10)	.490 (12,40)	160 lbf. (710 N)
	Prefix -0520	.010 (,250)	.300 (7,62)	.650 (16,50)	.360 (9,10)	.740 (18,7)	
3/16" (4,8mm)	Prefix -0614	.010 (,250)	.120 (3,05)	.480 (12,00)	.370 (9,30)	.570 (14,30)	220 lbf. (978 N)
	Prefix -0620	.010 (,250)	.300 (7,62)	.660 (16,70)	.370 (9,30)	.750 (18,90)	

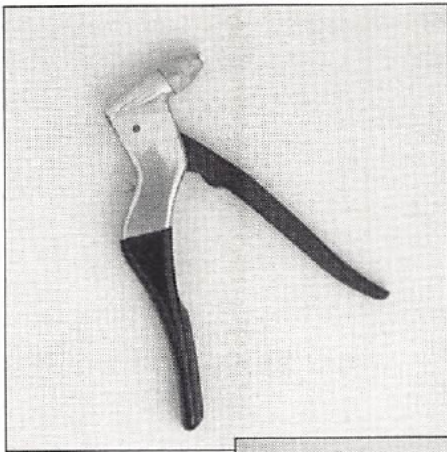
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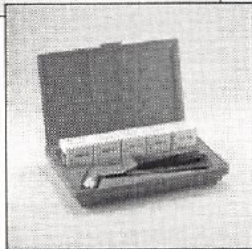
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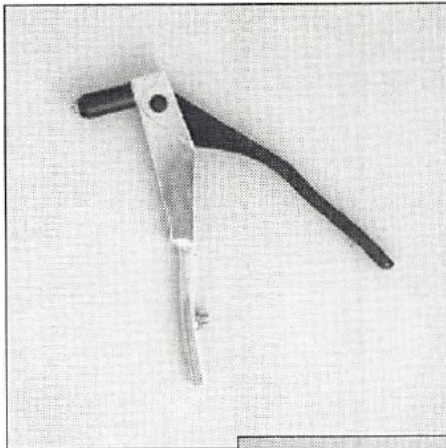
PRO-404 HAND RIVETER

The Avdel Cherry PRO-404 is a lightweight (17 oz.) hand tool that comes with two popular size nosepieces, 1015-4 and 1015-6, which will install 1/8" and 3/16" breakstem rivets.

The Avdel Cherry PRO-404 also comes in kit form, with a five box assortment of the most commonly used blind rivets, packaged in a rugged plastic case.



28



G-28 HAND RIVETER

The Avdel Cherry G-28 is a lightweight (13 oz.) hand tool that comes with two popular size nosepieces, 728A9-4 and 728A9-6, which will install 1/8" and 3/16" breakstem rivets. Other sizes and styles of rivets may also be set with this tool by obtaining applicable nosepieces.

The Avdel Cherry G-28 also comes in kit form, with a five box assortment of the most commonly used blind rivets, packaged in a rugged plastic case.



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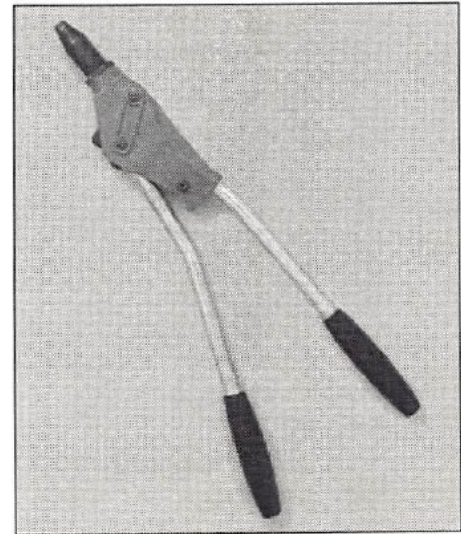
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Product Information

Placement Tools

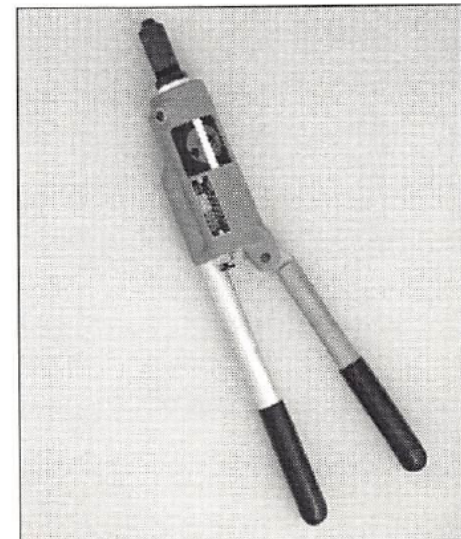
GH-4024 HAND RIVETER

The Avdel Cherry GH-4024 is a medium-duty (2-1/2 lbs.) hand tool that comes with two popular size nosepieces. Other nosepieces are available which will allow the tool to place up to 1/4" Monobolt® rivets.



GH-745A HAND RIVETER

The Avdel Cherry GH-745A is a heavy-duty (2-3/4 lbs.) hand operated hydraulic riveter that comes with two popular size nosepieces. 743A7-8Z and 743A7-5C6Z, which will install 1/4" Nail Rivets and Cherrymate® rivets. Other sizes and styles of rivets may also be set with this tool by obtaining the applicable nosepieces.



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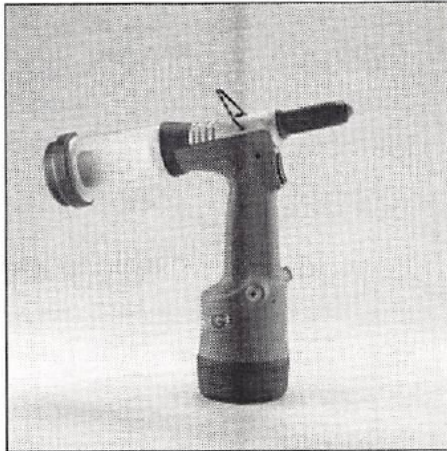


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G1
MODEL 71200-00001

The Model G1 is the most ergonomically designed hydro pneumatic breakstem rivet tool supplied by Avdel Cherry Textron. The weight of the tool makes it ideal for assembly line operation. The light trigger action coupled with a smooth response reduces operator fatigue and increases productivity. In addition, operator safety is enhanced with air shut-off devices, and the tool is immobilized when the stem catcher bottle is removed.

Weight	2.5 lbs. (1.13 kg.)
Pull Force	920 lbf. (4 kN.)
Stroke	.560 in. (14 mm.)

30



G2
MODEL 71210-00039

The Model G2 has been designed to place a broad range of breakstem rivets, by simply changing the nose tip. The universal three (3) jaw set-up allows the tool to place 1/8" conventional breakstem rivets up to some 1/4" rivets with only changing the tip.

Model 71200-00039 is provided complete with 1/8", 5/32" and 3/16" nose tips. The tool is provided standard with vacuum extraction and an on/off air switch.

Weight	3.2 lbs. (1.45 kg.)
Pull Force	1600 lbf. (7 kN.)
Stroke	.670 in. (17 mm.)

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Product Information

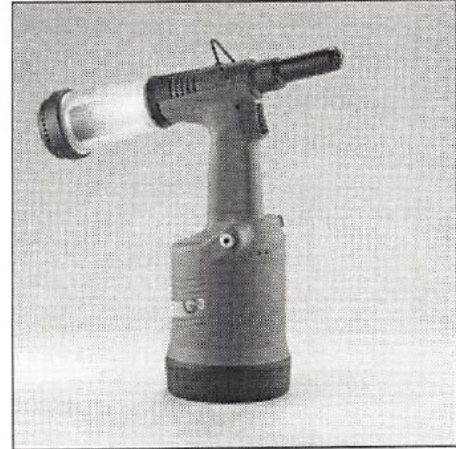
Placement Tools

G3

MODEL 71220-00201

The Model G3 is nearly half the weight of many tools of comparable capacity. As with the entire line of Genesis tools, the outer casing is made from glass reinforced thermo plastic. The universal three jaw set-up allows for placement of 1/8" Nail Rivets, through 1/4" Monobolt, with only a change of nose tip. The trigger action is light, quick, and responsive, increasing productivity and reliability.

Weight	3.6 lbs. (1.63 kg.)
Pull Force	2515 lbf. (11 kN.)
Stroke	.984 in. (25 mm.)

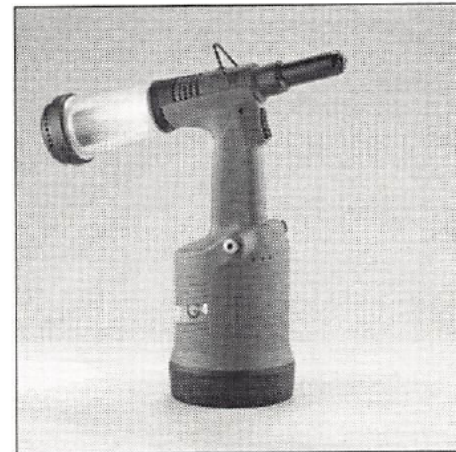


G4

MODEL 71230-00201

The strongest member of the Genesis family, G4, is able to place up to 1/4" Steel Hemlok and more. Despite that pull force and capacity, this tool still weighs only 3.6 lbs. Though lightweight, the robust construction can withstand demanding working conditions while maintaining the highest level of reliability.

Weight	3.6 lbs. (1.63 kg.)
Pull Force	3600 lbf. (16 kN.)
Stroke	.750 in. (19 mm.)



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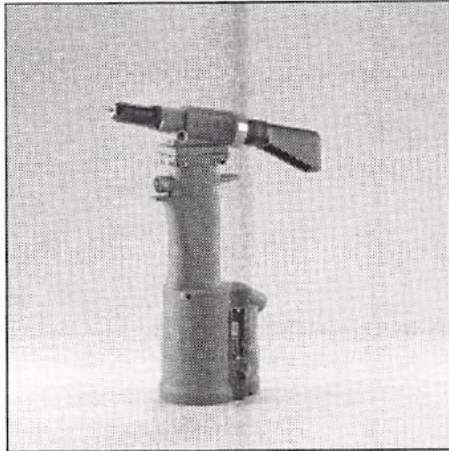


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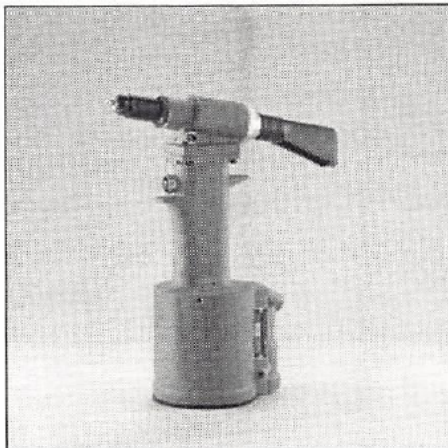


GH-702 POWER RIVETER

Model GH-702 is a lightweight hydro-pneumatic breakstem rivet tool designed to place up to 3/16" aluminum Nail Rivets. This proven, reliable tool is provided set up to place 1/8" Nail Rivets. Other sizes and styles of breakstem rivets may be placed just by changing the nosepieces. A mandrel collector bag may be attached to reduce clean-up.

Weight 3.5 lbs. (1.60 kg.)
Pull Force 1,000 lbf. (4.4 kN.)
Stroke .750" (19 mm.)

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GH-703 POWER RIVETER

Model GH-703 is a durable medium-weight hydro-pneumatic breakstem rivet tool. It is designed to place 3/16" blind rivets, regardless of material and aluminum 1/4" rivets. The tool is provided with two (2) nose tips to place 1/8" and 3/16" Nail Rivets. A mandrel collector bag may be attached to reduce clean-up.

Weight 4.75 lbs. (2.16 kg.)
Pull Force 2,000 lbs. (8.8 kN.)
Stroke .750" (19 mm.)

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Product Information

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GHA-743 POWER RIVETER

The Avdel Cherry GHA-743 is a heavy duty hydro-pneumatic rivet tool designed to place up to 1/4' steel/ stainless steel breakstem rivets including Monobolt® and Interlock®. It is provided with two (2) nosepieces to place 3/16" and 1/4" Nail Rivets.

The heavy duty construction makes it ideal for tough work environments. If required, it may be fitted with a mandrel collection bag to reduce clean-up operations.

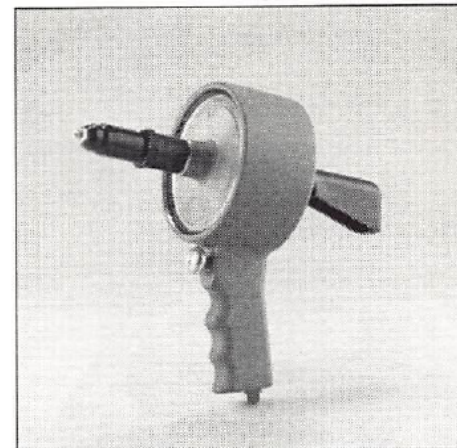
Weight 6.25 lb. (2.84 kg.)
Pull Force 3,600 lbs. (16 kN.)
Stroke .750 (19 mm.)



GH-780 POWER RIVETER

The model GH-780 is a unique tool which has been designed to provide a long stroke length while still being lightweight. It is an all pneumatic rivet tool capable of placing up to 3/16" aluminum breakstem product. It is provided with two (2) nosepieces to place 1/8" and 3/16" Nail Rivets. As with all the GH series tools, it may be provided with a stem catcher bag to reduce clean-up operations.

Weight 3 lbs. (1.36 kg.)
Pull Force 1000 lbf. (4.4 kN.)
Stroke 1.125" (28.5 mm.)



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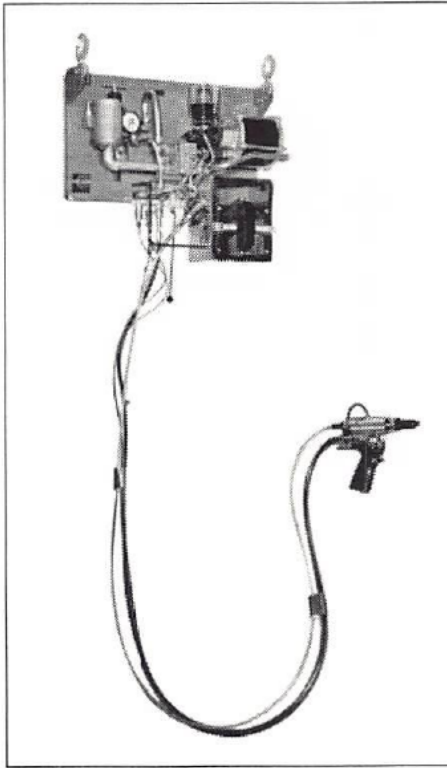


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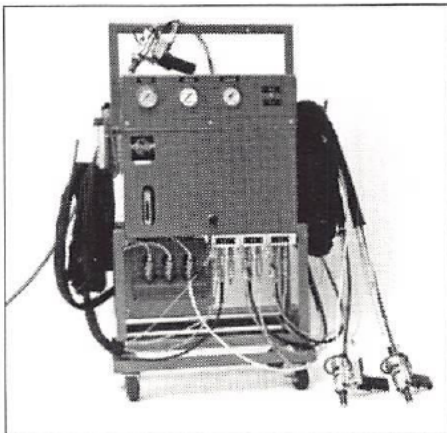
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MODEL RS-155

Model RS-155 is a pneumatic-hydraulic unit equipped with a built-in spent mandrel collector, a hose assembly, and a setting tool capable of installing 1/8" to 1/4" diameter rivets. With the three tool models available, the RS-155 provides more versatility and superior performance over all other systems of equivalent size. The lightweight tool design, combined with a flexible hose assembly, ensures the operator hours of effortless rivet installation.

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MODEL RS-255

Model RS-255 is a pneumatic-hydraulic, multiple-tool power riveting system. Designed to meet the requirements of high production environments, the RD-255 can power up to three riveters simultaneously or independently. One compressed air source at 80 P.S.I. is all that is required to produce over 3,000 lbs. of pulling force to set a wide range of blind rivets from 1/8" to 1/4" diameter.

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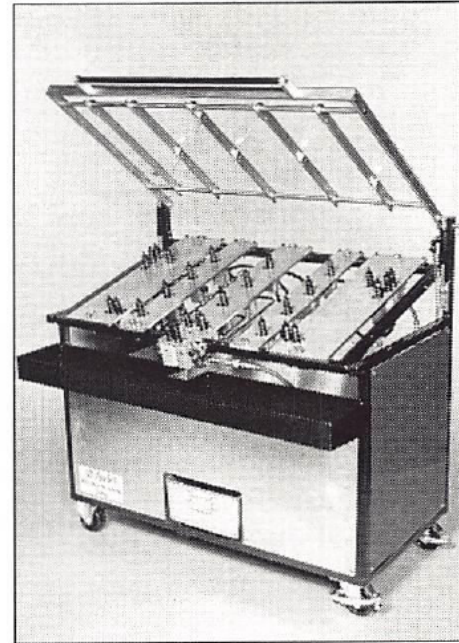
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Product Information

Placement Tools

HYDRA 2000

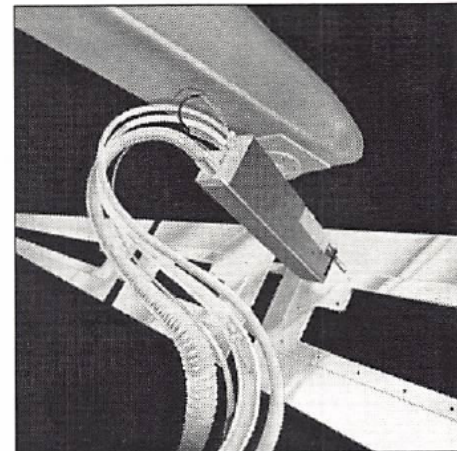
Multiple numbers of Avdel Cherry placing heads can be incorporated into a Hydra 2000 workstation for simultaneous placement of blind rivets. Interlocking safety shields and fixtures are used to ensure a consistent placement with each and every installation. In addition, using pick-and-place mechanisms, Avdel Cherry multi-head equipment can be made as automated and operator-independent as needed. These systems can place the entire range of our breakstem fasteners, from 3/32" up to 1/4" diameter. Standard configurations or custom built units can be provided.



VIKING

The Viking 360 System has been designed to meet the growing demand for flexible rivet installation equipment which is fully automatic in operation and can be readily integrated into robotic applications. Fasteners are loaded into vibratory bowl feeder ready for automated assembly. The machine features a comprehensive range of sensors and control elements.

The modular riveting head can be combined with an air powered drilling head. With these two heads mounted on a robot, considerable flexibility of operation is achieved with the umbilical, which can be up to nine meters in length.



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Placement Tools Matrix

Cross Reference

Tooling and Fastener Cross Reference													
	Diam.	GH702	GH703	GHA743	GH780	G1	G2	G3	G4	PRO404	G28	GH4024	GH745A
N Rivet™	3/32	Y	Y	(2)	Y	Y	Y	Y	Y	Y	Y	N	N
	1/8	Y	Y	(2)	Y	Y	Y	Y	Y	Y	Y	N	N
	5/32	AAP, BSP, SSP	Y	(2)	AAP, BSP, SSP	AAP, BSP, SSP	Y	Y	Y	AAP, BSP, SSP	AAP, BSP, SSP	N	N
	3/16	AAP, BSP	Y	Y	AAP, BSP	AAP, BSP	Y	Y	Y	AAP	AAP	Y	Y
	1/4	N	(1) AAP, BSP	Y	N	N	AAP, BSP	Y	Y	N	N	Y	Y
Closed End (BSPH Series)	1/8	Y	Y	(2)	Y	Y	Y	Y	Y	Y	Y	N	N
	5/32	Y	Y	(2)	Y	Y	Y	Y	Y	Y	Y	N	N
	3/16	N	Y	Y	N	N	Y	Y	Y	N	N	Y	Y
	1/4	N	(1) Y	Y	N	N	N	Y	Y	N	N	Y	Y
Avex®	1/8	Y	Y	(2)	Y	Y	Y	Y	Y	Y	Y	N	N
	5/32	Y	Y	(2)	Y	Y	Y	Y	Y	Y	Y	N	N
	3/16	N	Y	Y	N	N	Y	Y	Y	N	N	Y	Y
	1/4	N	(1) Y	Y	N	N	Y	Y	Y	N	N	Y	Y
Stavex®	3/16	N	Y	Y	N	N	Y	Y	Y	N	N	Y	Y
	1/4	N	N	Y	N	N	N	Y	Y	N	N	Y	Y
Bulbex®	5/32	Y	Y	(2)	Y	Y	Y	Y	Y	Y	Y	N	N
	3/16	Y	Y	Y	Y	Y	Y	Y	Y	Y	Y	N	N
Avinox® II	1/8	Y	Y	(2)	Y	Y	Y	Y	Y	Y	Y	N	N
	5/32	N	Y	(2)	N	N	Y	Y	Y	N	N	N	N
	3/16	N	Y	Y	N	N	Y	Y	Y	N	N	Y	Y
Avibulb®	1/8	Y	Y	(2)	Y	Y	Y	Y	Y	Y	Y	N	N
	5/32	N	Y	(2)	N	N	Y	Y	Y	N	N	N	N
	3/16	N	Y	Y	N	N	Y	Y	Y	N	N	Y	Y
Cherrymate®	3/16	Y	Y	(2)	Y	Y	Y	Y	Y	Y	Y	N	N
	1/4	BALM, BSLM	Y	Y	BALM, BSLM	BALM, BSLM	Y	Y	Y	BALM, BSLM	BALM, BSLM	Y	Y
T-Lok®	5/32	Y	Y	(2)	Y	Y	Y	Y	Y	Y	Y	N	N
	3/16	Y	Y	Y	Y	N	Y	Y	Y	Y	Y	Y	Y

Notes: (1) Requires H743A-8Z pulling head.
 (2) Requires H703 pulling head and applicable nose piece.

The matrix above simply represents whether the tool listed is capable of placing the respective fastener. To obtain specific nose equipment details, refer to the operations manual or contact Avdel Cherry Textron technical services.

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