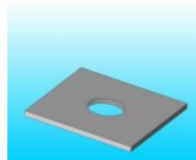


Hank Round Pattern Rivet Bush Installation Guide

This article provides a 4-point step-by-step storyboard style installation guide for the Hank® round pattern rivet bushes.

The round pattern bush features a serrated spigot providing a durable and effective alternative to the Hexagon pattern. When installed, the serrations provide discreet anchorage against Torsional resistance and pull out loads. (See step 4 for a cross-section illustration).

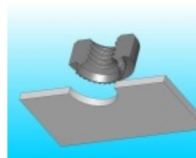
Like the hexagon bush, the round pattern is designed to be riveted or 'peened' over the sheet metal to provide a strong and re-usable thread assembly.



Step 1

Ensure the correct spigot length has been selected for sheet thickness being used. Select the appropriate hole size from the table below for the bush size required.

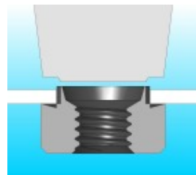
Punch the hole diameter into the sheet material.



Step 2

Insert the spigot end into the hole on the side opposite the mating face. Ensure both bush and plate are aligned along the same axis.

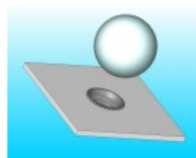
If the bush is not seated 'square' in the hole, the joint will be imperfect and mating threads will mis-align.



Step 3

Automated Installation

Using a profiled punch, apply only sufficient pressure to 'peen' the spigot and its serrations over into the sheet metal. Providing Torsional (rotational) resistance. After installation the spigot is to be flush.



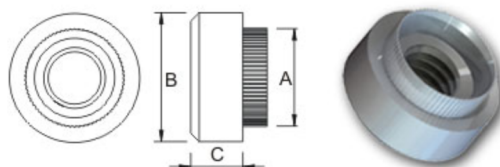
Step 4

Manual Installation

Using the profile punch or ball bearing, locate either tool onto the spigot and strike with a hammer to 'peen' the spigot and embed the Hexagons' 6 points into the sheet metal. Several blows may be required to fully peen over the spigot to make a flush and secure fit.

Using the table below with reference to the specific size of the round pattern rivet bush, select the correct Hole size for the installation of the fastener.

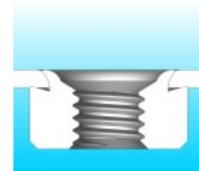
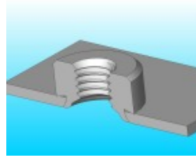
For the best dimensional accuracy and therefore performance, TR Fastenings recommends that all holes in the sheet metal application be punched. To install the fastener into the punched Hole a profiled punch or a ball bearing of a suitable size is required. The profiled punch can be sourced from the TR Fastenings sales team. Note it is essential that the recommended Hole tolerances be observed.



Metric Dimensions										
Thread form		M2.5	M3	M3.5	M4	M5	M6	M8	M10	M12
Diameter of spigot +0.00 -0.13mm	A	5.54	5.54	6.73	6.73	7.92	9.52	12.70	15.87	19.05
Width across flats ±0.15mm	B	7.92	7.92	9.52	9.52	11.10	12.70	15.87	19.05	25.40
Depth of body ±0.13mm	C	3.17	3.17	3.17	3.17	3.81	5.08	6.35	7.62	10.16
Recommended hole size +0.05 -0.00mm		5.54	5.54	6.73	6.73	7.92	9.52	12.70	15.87	19.05

Imperial Dimensions										
Thread Form	BSW/F	-	1/8"	-	5/32"	3/16"	1/4"	5/16"	3/8"	1/2"
	BA	8	6.5	4	3	2	0	-	-	-
	UNC	2	4	6	8	10	1/4"	5/16"	3/8"	1/2"
	UNF	2	4	6	8	10	1/4"	5/16"	3/8"	1/2"
Diameter of spigot +0.00 -0.05"	A	.218	.218	.265	.265	.312	.375	.500	.625	.750
Width across flats ±0.010"	B	.312	.312	.375	.375	.437	.500	.625	.750	1.000
Depth of body ±0.005"	C	.125	.125	.125	.125	.150	.200	.250	.300	.400
Recommended hole size +0.002 -0.000"		.218	.218	.265	.265	.312	.375	.500	.625	.750

Joint Assembly



Note: Due to the fact that fastening applications differ greatly, the above information is for guidance only and is correct to the best of our knowledge. The customer must satisfy themselves with the performance of the fastener and validity of the data. TR Fastenings will not be held responsible for any failure that may occur from the use of this information.



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