



Tech Tip

12-0105-2

Product Affected – Monobolts

Complaint: The center pulls through the body of the monobolt or breaks off on the monobolts we are installing.

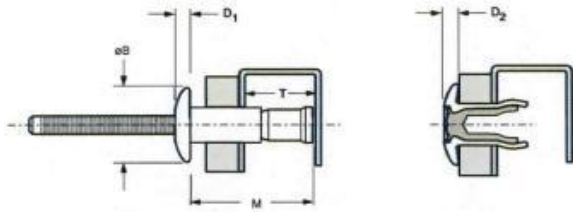
Cause: There are several conditions which can cause this

- The tip on the gun being used may be worn
- An improper sized monobolt being used
- Improper gun tip being used
- Material too thin for the monobolt

Correction: Figure #1 shows a chart indicating the minimum and maximum material thickness (**OUTLINED IN RED**) as well as the minimum and maximum drill size (**OUTLINED IN GREEN**). Figure #2 shows the gun tip and where to monitor for wear. Figure #3 shows how that section of the tip works to essentially “lock” the stem into place. A regular rivet gun does not produce this affect and should not be used with monobolts. Figure #4 shows how the installed monobolt can be checked visually for the locked stem.

Do not depend on the monobolt to pull panels together when fastening

NOTE: You can see an animated illustration of how a monobolt is designed to work at <http://www.avdel-global.com/en/products/breakstem-fasteners/monoboltr.html>



ø	[Red Box]		[Green Box]		M	ø B	D ₁	T	D ₂	[Double Arrow]	[Shield]
	min.	max.	min.	max.							
nom.					max.	max.	max.	min.	max.	lbf ²³	lbf ²⁴
3/16" (4.8 mm)	.064	.270	.193	.201	.716	.395	.083	.410	.073	1450	1150
	.064	.437			.962			.530			
1/4" (6.4 mm)	.080	.375	.260	.275	.933	.525	.114	.480	.104	2650	2350
	.080	.625			1.296			.645			
3/8" (10 mm)	.120	.625	.392	.409	1.425	.798	.160	.875	.156	5940	3953

Figure #1

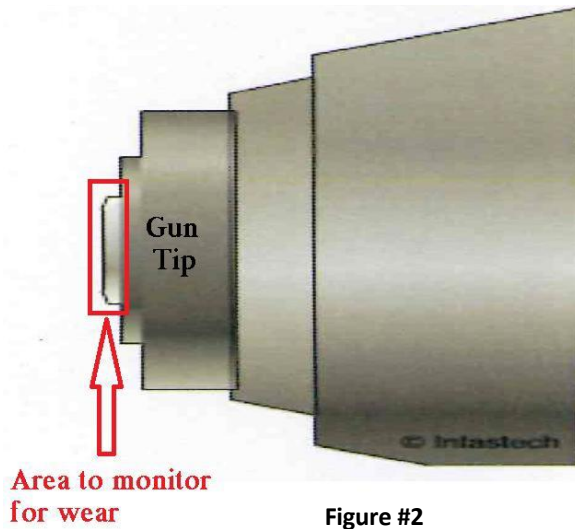


Figure #2

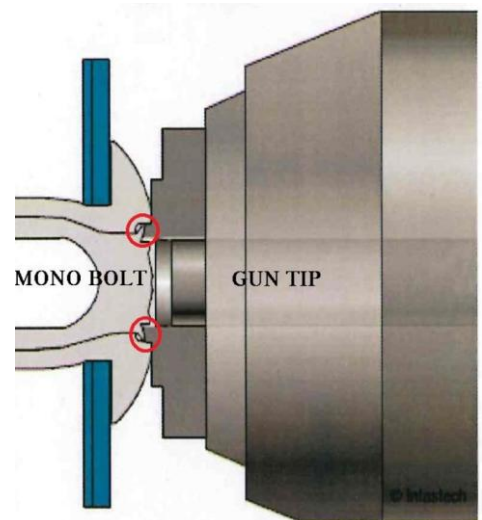


Figure #3

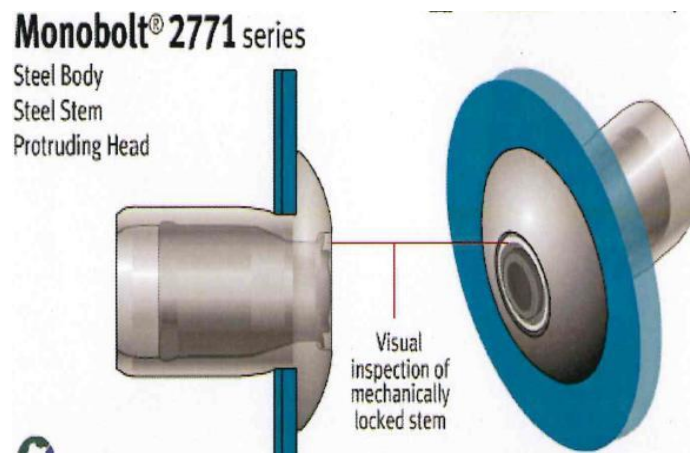


Figure #4

For more information contact our nearest Service Department

Chittenango: 315-687-3969 - 1-800-962-5768

➤ **Daryl Wallace or Brian Lamaitis**

Rochester: 585-424-3320 - 1-800-463-3232

➤ **Gary Chichester or Dave Schaub**

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➤ **Ben Reiling or Steve Searles**