



5.5 COUNTERSINKING AND DIMPLING

Flush riveting requires that a flat or "mushroom" set be used and that the skin around the rivet hole be countersunk either by dimpling or machining. Be sure to remove any vinyl coating before machine countersinking or dimpling the parts. Dimple countersinking will be simply referred to as dimpling for the remainder of this manual.

For AD3 rivets, a total material thickness between .016 [.4 mm] and .032 [.8 mm] must be dimpled. Material thickness between .032 [.8 mm] and .040 [1.0 mm], should be dimpled, but a countersink may be used if necessary. Finally, for a thickness of .050 [1.3 mm] and above the material must be countersunk.

For AD4 rivets, .050 is the minimum thickness that may be countersunk.