



**DECLARATION OF PERFORMANCE NR:
DOP 15977/3 ACC**

Version: V-1.2018

ACCORDING TO THE REGULATION (EU) No 574/2014 OF 21 FEBRUARY 2014r.

1. Unique identification code of the product-type:

Open-end aluminum-carbon steel, aluminum-stainless steel, stainless steel-stainless steel rivets.
Close-end aluminum-carbon steel, aluminum-stainless steel, stainless steel-stainless steel rivets.

2. Intended use or uses of the construction product:

Close-end rivets are designed for waterproof fastening overlap joints of different elements
Open-end rivets are designed for economical fastening of different elements in places that do not require tightness (lack of moisture).

3. Manufacturer:

Etanco Sp. z o. o., Al. Jana Pawła II 1, 81-345 Gdynia,
Adres zakładu produkcyjnego : ul. Olsztyńska 30 , 11-130 Orneta

4. Authorized representative:

Not applicable

5. System of assessment and verification of constancy of performance:

System 4 according Annex V Regulation No 305/2013 of the European Parliament and of the Council of 9 March 2011 (Construction Product Regulation - CPR)

6. Harmonized standard:

PN-EN ISO 15973, PN-EN ISO 15977

Notified body or bodies:

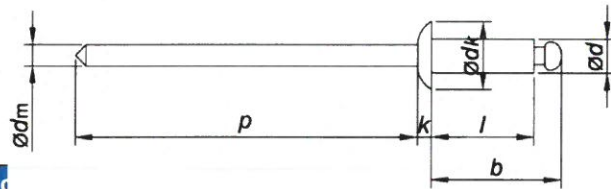
N/A

7. Declared performance:

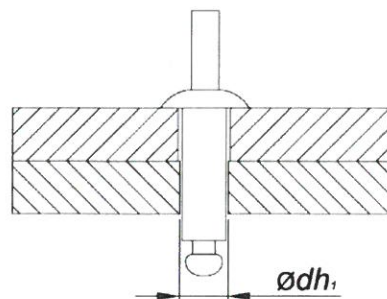
Essential characteristics		Performance	Harmonized technical specification
Close-end rivets	Shape and dimensions	according to fig. 1 and table 1 of the standard	PN-EN ISO 15973
	Mechanical properties	according to table 3 of the standard	
Open-end rivets	Shape and dimensions	according to fig. 1 and table 1 of the standard	PN-EN ISO 15977
	Mechanical properties	according to table 3 of the standard	

Rivet dimensions [mm] acc. PN-EN ISO 15977

		no m.	2,40	3,00	3,20	4,00	4,80	5,00	6,00	6,40
Proper rivet	d	max	2,48	3,08	3,28	4,08	4,88	5,08	6,08	6,48
		min	2,25	2,85	3,05	3,85	4,65	4,85	5,85	6,25
	d	max	5,00	6,30	6,70	8,40	10,10	10,50	12,60	13,40
	k	min.	4,20	5,40	5,80	6,90	8,30	8,70	10,80	11,60
	k	max	1,00	1,30	1,30	1,70	2,00	2,10	2,50	2,70
Core	d _c	max	1,55	2,00	2,00	2,45	2,95	2,95	3,40	3,90
	p	min.	25,00	25,00	25,00	27,00	27,00	27,00	27,00	27,00
Length of the rivet with the head of the core	b	max	$l_{max} + 3,5$	$l_{max} + 3,5$	$l_{max} + 4,0$	$l_{max} + 4,0$	$l_{max} + 4,5$	$l_{max} + 4,5$	$l_{max} + 5,0$	$l_{max} + 5,5$
Rivet length	lb	nom. = min.	Recommended joining ranges							
		max								
4,0	5,0	from 0,5 to 2,0	from 0,5 to 1,5	-	-	-	-	-	-	
6,0	7,0	from 2,0 to 4,0	from 1,5 to 3,5	from 1,0 to 3,0	from 1,5 to 2,5	-	-	-	-	
8,0	9,0	from 4,0 to 6,0	from 3,5 to 5,0	from 3,0 to 5,0	from 2,5 to 4,0	from 2,0 to 3,0	-	-	-	
10,0	11,0	from 6,0 to 8,0	from 5,0 to 7,0	from 5,0 to 6,5	from 4,0 to 6,0	from 3,0 to 5,0	-	-	-	
12,0	13,0	from 8,0 to 9,5	from 7,0 to 9,0	from 6,5 to 8,5	from 6,0 to 8,0	from 5,0 to 7,0	from 3,0 to 6,0	-	-	
16,0	17,0	-	from 9,0 to 13,0	from 8,5 to 12,5	from 8,0 to 12,0	from 7,0 to 11,0	from 6,0 to 10,0	-	-	
20,0	21,0	-	from 13,0 to 17,0	from 12,5 to 16,5	from 12,0 to 15,0	from 11,0 to 15,0	from 10,0 to 14,0	-	-	
25,0	26,0	-	from 17,0 to 22,0	from 16,5 to 21,0	from 15,0 to 20,0	from 15,0 to 20,0	from 14,0 to 18,0	-	-	
30,0	31,0	-	-	-	from 20,0 to 25,0	from 20,0 to 25,0	from 18,0 to 23,0	-	-	



Diameters d		
PN-EN ISO 15977		
d nom.	dh1	
	min.	max
2,4	2,5	2,6
3,0	3,1	3,2
3,2	3,3	3,4

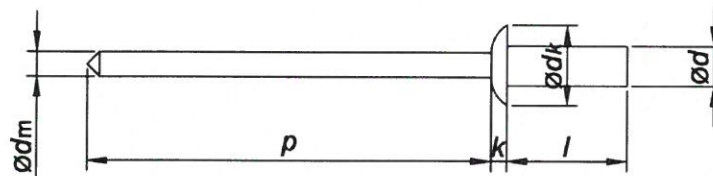


4,0	4,1	4,2
4,8	4,9	5,0
5,0	5,1	5,2
6,0	6,1	6,2
6,4	6,5	6,6

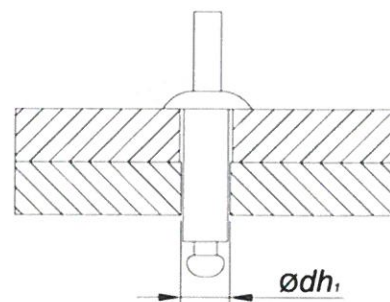
Mechanical properties of rivets acc. PN-EN ISO 15977					
d nom. [mm]	Class L		Class H		Core breaking load maz [N]
	Shear load min. [N]	Tensile load min. [N]	Shear load min. [N]	Tensile load min. [N]	
2,4	250	350	350	550	2000
3,0	400	550	550	850	3000
3,2	500	700	750	1100	3500
4,0	850	1200	1250	1800	5000
4,8	1200	1700	1850	2600	6500
5,0	1400	2000	2150	3100	6500
6,0	2100	3000	3200	4600	9000
6,4	2200	3150	3400	4850	11000

Rivet dimensions [mm] acc. PN-EN ISO 15973						
Proper rivet	d	nom.	3,20	4,00	4,80	6,40
		max	3,28	4,08	4,88	6,48
		min	3,05	3,85	4,65	6,25
	dk	max	6,70	8,40	10,10	13,40
		min.	5,80	6,90	8,30	11,60
	k	max	1,30	1,70	2,00	2,70
Core	d,	max	1,85	2,35	2,77	3,71
	p	min.	25,00	25,00	27,00	27,00

I		Recommended joining ranges			
nom. = min.	max				
6,5	7,5	from 0,5 to 2,0	-	-	-
8,0	9,0	from 2,0 to 3,5	from 0,5 to 3,5	-	-
8,5	9,5	-	-	from 0,5 to 3,5	-
9,5	10,5	from 3,5 to 5,0	from 3,5 to 5,0	from 3,5 to 5,0	-
11,0	12,0	from 5,0 to 6,5	from 5,0 to 6,5	from 5,0 to 6,5	-
12,5	13,5	from 6,5 to 8,0	from 6,5 to 8,0	-	from 1,5 to 6,5
13,0	14,0	-	-	from 6,5 to 8,0	-
14,5	15,5	-	from 8,0 to 10,0	from 8,0 to 9,5	-
15,5	16,5	-	-	-	from 6,5 to 9,5
16,0	17,0	-	-	from 9,5 to 11,0	-
18,0	19,0	-	-	from 11,0 to 13,0	-
21,0	22,0	-	-	from 13,0 to 16,0	-



Diameters of transition holes [mm] acc. PN-EN ISO 15973		
d	dh1	
nom.	min.	max
3,2	3,3	3,4
4,0	4,1	4,2
4,8	4,9	5,0
6,4	6,5	6,6



Mechanical properties of rivetsacc. PN-EN ISO 15973			
d nom.	Shear load min.	Tensile load min.	Core Breaking load max
[mm]	[N]	[N]	[N]
3,2	1100	1450	3500
4,0	1600	2200	5000
4,8	2200	3100	7000
6,4	3600	4900	10230

8. Relevant technical documentation or special technical documentation

Not applicable

Performance properties of the product described above are compatible with the set of declared performance characteristics. This declaration of performance is issued in accordance with Regulation (EU) No 305/2011 under the sole responsibility of the manufacturer referred above

On behalf of the producer signed:

Aleksander Stec

in Ornetá, date 02.01.2018

Aleksander Stec
Product Manager
Etanco Sp. z o.o.