

Specification for

Snap head aluminium and aluminium alloy rivets*

ICS 49.030.60

*Index form of title: Rivets, snap head, in L36, L37, L58 and L86 materials.

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Foreword

Publishing information

BS 2SP 77 to BS 2SP 80:1973+A4:2015 is published by BSI Standards Limited, under licence from The British Standards Institution, and came into effect on 31 January 2015. It was prepared by Technical Committee ACE/12, *Aerospace Fasteners and Fastening*. A list of organizations represented on this committee can be obtained on request to its secretary.

Supersession

BS 2SP 77 to BS 2SP 80:1973+A4:2015 supersedes BS 2SP 77 to BS 2SP 80:1973 (incorporating Amendments No.1, No. 2 and No. 3) which is withdrawn.

Information about this document

These standards form part of a series of British Standards for rivets prepared at the request of the aerospace industry. The 1958 edition provided for ranges of snap head aluminium and aluminium alloy rivets with head proportions and shank diameters basically the same as those used hitherto. In general, the dimensions of the rivets were more closely defined than previously, although the shank tolerances on sizes above ½ in are wider than those adopted in BS SP 68 to BS SP 71, “100° countersunk precision head aluminium and aluminium alloy rivets”.

The distribution of the shank tolerances follows the American practice of allocating the greater part of the tolerance to the positive side, as compared with the practice in A.S. Standards for rivets of distributing the tolerances about the nominal diameter. This principle, as well as the proportions of the rivet heads, has been endorsed by Technical Committee ISO/TC 20 — Aircraft and space vehicles, of the International Organization for Standardization, as have the identification markings contained in this revision of the standards. A method for the identification of undyed versions of the rivets is also given.

Details of rivets with radiused tails for use in auto-riveting machines are given in Appendix A.

Text introduced or altered by Amendment No. 4 is indicated in the text by tags **A4** **A4**. Minor editorial changes are not tagged. Previous amendments are not indicated.

Presentational conventions

The provisions of this standard are presented in roman (i.e. upright) type. Its requirements are expressed in sentences in which the principal auxiliary verb is “shall”.

Commentary, explanation and general informative material is presented in smaller italic type, and does not constitute a normative element.

Contractual and legal considerations

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

Compliance with a British Standard cannot confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 5 and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

Amendments issued since publication

Amd. No.	Date	Comments
1884	January 1976	
2389	November 1977	
3264	June 1980	
A4	January 2015	See Foreword

This British Standard, having been approved by the Aerospace Industry Standards Committee, was published under the authority of the Executive Board on 31 October 1973

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