

BS 2SP 87 and 2SP 88:1973+A3:2015



BSI Standards Publication

# AEROSPACE SERIES

## 100° countersunk head high nickel-copper alloy rivets\*

\* Index form of title: Rivets, 100° countersunk head, in DTD 204 material.

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## Foreword

### Publishing information

BS 2SP 87 and 2SP 88:1973+A3:2015 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 & Fastening*. A list of organizations represented on this committee can be obtained on request to its secretary.

### Supersession

BS 2SP 87 and 2SP 88:1973+A3:2015 supersedes BS 2SP 87 and 2SP 88:1973 (incorporating Amendments No. 1 and No. 2), which is withdrawn.

### Information about this document

BS 2SP 87 and 2SP 88 forms part of a series for rivets, prepared at the request of the aerospace industry. This series provides for rivets, with 100° angle countersunk heads controlled by the 'flushness tolerance' method first used for countersunk head fasteners in BS 1981, 'Unified machine screws and machine screw nuts' and later adopted in British Standards SP 68 to SP 71, '100° countersunk precision head aluminium and aluminium alloy rivets'.

In general, the aim has been to provide in these British Standards for a range of rivets equivalent to those manufactured in accordance with the American specification MS 20427. The rivet heads and shanks are not of the same degree of precision as those specified in British Standards SP 68 to SP 71, although they are more closely controlled than in countersunk head high nickel-copper alloy rivets hitherto for aerospace use. The markings of the rivets in this revision of the standards are those agreed by ISO/TC20 – Aircraft and space vehicles.

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

*NOTE The figures in inch units are to be regarded as the standard. Accurate metric conversions should be based on the tables in BS 350.*

This standard makes reference to the following standards:

#### British Standards:

BS 350, *Conversion factors for units*

BS EN 2133, *Aerospace series — Cadmium plating of steels with specified tensile strength  $\leq 1\,450$  MPa, copper, copper alloys and nickel alloys*

#### MoD Defence Equipment and Support Standards:

DTD 204, *Nickel-Copper Alloy Cold Drawn Wire for Rivets*

Def Stan 03-19, *Electro-Deposition of Cadmium*

The start and finish of text introduced or altered by Amendment No. 3 are indicated in the text by tags **A3** **A3**. 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.*