

Specification for

Rivets —

For general engineering purposes

UDC 621.884

NO COPYING WITHOUT BSI PERMISSION EXCEPT AS PERMITTED BY COPYRIGHT LAW

BSI
Documents

AVA

Document Sharing Hub

Co-operating organizations

The Mechanical Engineering Industry Standards Committee, under whose supervision this British Standard was prepared, consists of representatives from the following Government departments and scientific and industrial organizations:

Associated Offices' Technical Committee	Institution of Civil Engineers
Association of Consulting Engineers	Institution of Gas Engineers
Association of Mining Electrical and Mechanical Engineers	Institution of Heating and Ventilating Engineers
Board of Trade	Institution of Mechanical Engineers*
British Chemical Plant Manufacturers' Association	Institution of Mechanical Engineers (Automobile Division)*
British Compressed Air Society	Institution of Production Engineers
British Electrical and Allied Manufacturers' Association*	Locomotive and Allied Manufacturers' Association of Great Britain*
British Gear Manufacturers' Association	London Transport Board
British Internal Combustion Engine Manufacturers' Association	Machine Tool Trades Association
British Steel Industry*	Ministry of Defence
British Mechanical Engineering Confederation	Ministry of Defence, Army Department
British Pump Manufacturers' Association	Ministry of Power
Crown Agents for Oversea Governments and Administrations	Ministry of Public Building and Works
Department of Employment and Productivity (H.M. Factory Inspectorate)	Ministry of Technology
Electricity Council, the Central Electricity Generating Board and the Area Boards in England and Wales	Ministry of Technology — National Engineering Laboratory
Engineering Equipment Users' Association	Ministry of Transport*
Gas Council	National Coal Board
	National Physical Laboratory (Ministry of Technology)
	Royal Institute of British Architects

The Government department and scientific and industrial organizations marked with an asterisk in the above list, together with the following, were directly represented on the committee entrusted with the preparation of this British Standard.

Aluminium Federation	Greater London Council
Association of British Railway Carriage and Wagon Manufacturers	Institute of Iron and Steel Wire Manufacturers
Board of Trade	Institution of Structural Engineers
British Aluminium Holloware Manufacturers' Association	Lloyd's Register of Shipping
British Constructional Steelwork Association	Ministry of Defence, Navy Department
British Friction Materials Council	North East Coast Institution of Engineers and Shipbuilders
British Railways Board	Small Rivet Association
British Rivet Association	Society of British Aircraft Constructors
Bureau Veritas	Society of Motor Manufacturers and Traders Ltd.
Copper Development Association	

This British Standard, having been approved by the Mechanical Engineering Industry Standards Committee, was published under the authority of the Executive Board on 24 July 1970

© BSI 01-2000

The following BSI references relate to the work on this standard:
Committee reference MEE/44, MEE/54, MEE/67
Draft for comment 68/26642

ISBN 0 580 06411 5

Amendments issued since publication

Amd. No.	Date	Comments

Contents

	Page
Co-operating organizations	Inside front cover
Foreword	ii
1 Scope	1
2 Definitions	1
3 Materials	1
4 Method of manufacture	1
5 Workmanship	1
6 Shapes of heads and shanks	1
7 Radius under head	1
8 Dimensions and tolerances	1
Appendix A Tentative range of preferred nominal lengths associated with shank diameters	9
Table 1 — Cold forged snap head rivets	2
Table 2 — Hot forged snap head rivets	3
Table 3 — Cold forged universal head rivets	4
Table 4 — Hot forged universal head rivets	5
Table 5 — Cold forged flat head rivets	6
Table 6 — Cold forged 90° countersunk head rivets	7
Table 7 — Hot forged 60° countersunk and raised countersunk head rivets	8

Foreword

This British Standard is published under the authority of the Mechanical Engineering Industry Standards Committee and is for rivets to basic metric dimensions. It is based on ISO/Recommendation ISO/R 1051¹⁾. The snap head rivet dimensions 14 mm diameter and above have been taken from DIN 124²⁾. The shapes of heads have been restricted to those in common use in this country. A chart showing a tentative range of preferred nominal lengths in association with shank diameters is included in Appendix A which will be reviewed in the light of usage.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself 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 9 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.

¹⁾ ISO/R 1051:1969, "Rivet shank diameters (diameter range 1 mm to 36 mm)".

²⁾ DIN 124, "Round head rivets for steel structures".

1 Scope

This British Standard specifies the materials, dimensions and head shapes of rivets in metric sizes ranging from 1 mm to 39 mm diameter intended for general engineering purposes.

2 Definitions

For the purposes of this British Standard, the following definitions apply:

2.1

nominal diameter

the diameter of the shank

2.2

nominal length of rivets other than countersunk or raised countersunk rivets

the length from the underside of the head to the end of the shank

2.3

nominal length of countersunk and raised countersunk rivets

the distance from the periphery of the head to the end of the rivet measured parallel to the axis of the rivet

2.4

manufactured head

the head on the rivet as received from the manufacturer

3 Materials

The rivets shall be made from mild steel, copper, brass, pure aluminium, aluminium alloys or other suitable metal.

4 Method of manufacture

The rivets shall be made by hot or cold forging methods as specified in Table 1 to Table 7 as appropriate.

5 Workmanship

The rivets shall be free from harmful defects.

6 Shapes of heads and shanks

The heads of the rivets shall conform to the shapes shown in Table 1 to Table 7 as appropriate.

7 Radius under head

The radius under the head of the rivet shall run smoothly into the face of the head and shank without any step or discontinuity.

8 Dimensions and tolerances

8.1 The dimensions and tolerances for the rivets shall be in accordance with Table 1 to Table 7 as appropriate.

8.2 A chart showing a tentative range of preferred nominal lengths associated with shank diameters is shown in Appendix A.