

1. Scope

1.1 Scope. This standard establishes the requirements for metric drive pin blind rivets suitable for use in joining the component parts of an assembly.

1.2 Definitions

1.2.1 Blind Rivet. A blind rivet is a blind fastener which has a self-contained mechanical or other feature which permits the formation of an upset on the blind end of the rivet and expansion of the rivet shank during rivet setting to join the component parts of an assembly.

1.2.2 Drive Pin. A drive pin rivet is a blind rivet consisting of a rivet body and a pin which is contained in the rivet body and which projects above the rivet head. In the setting operation, the rivet is inserted into the components to be joined, and the pin is forced into the rivet body until the pin end is flush with the top of the rivet head. This action flares or spreads the end of the rivet body forming a blind head.

1.2.3 Definitions of other terms used in this standard are given in IFI-110/550, *Glossary of Terms Relating to Blind Rivets*.

2. Designations

2.1 Styles. The two basic styles of metric drive pin blind rivets are designated as protruding head and flush head. Flush head rivets are available in two styles designated as 100 deg countersunk head and 78 deg countersunk head.

2.2 Grades. The material combinations of drive pin blind rivets are designated as grades with each material combination representing a different combination of rivet body material and mandrel material as given in Table 1.

**Table 1 Grades of Metric Drive Pin
Blind Rivets**

Grade Designation	Rivet Body Material	Pin Material
12	Aluminum Alloy 5056	Aluminum Alloy
14	Aluminum Alloy 2117	Aluminum Alloy
30	Low Carbon Steel	Carbon Steel
31	Low Carbon Steel	300 Series Stainless Steel
60	Aluminum Alloy 2117	300 Series Stainless Steel
61	Aluminum Alloy 5056	300 Series Stainless Steel

NOTE: At manufacturer's option, Grade 31 rivets may be substituted for Grade 30.

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Published and issued by the Industrial Fasteners Institute of Independence, OH		Issued: 1999 Revised:

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2.3 Design. The design of drive pin blind rivets shall be in accordance with the practice of the manufacturer.

3. Requirements

3.1 Materials and Processes

3.1.1 Material. Rivet bodies and mandrels shall be made of the material specified for the grade in Table 1. When the specific material analysis is not given, the analysis shall be selected by the manufacturer.

3.1.2 Heat Treatment. Rivet components shall be heat treated when necessary. Heat treatment shall be in accordance with good commercial practice.

3.1.3 Finish. Grade 60 rivet bodies may be anodized at the manufacturer's option except when specified by the purchaser. The stainless steel pins of Grades 60, 61, and 31 may be passivated or mill finish in accordance with the practice of the manufacturer.

Unless otherwise specified, Grades 30 and 31 rivet bodies shall be cadmium plated with a minimum plating thickness of 0.0038 mm.

3.2 Dimensional Requirements

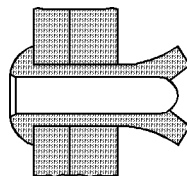
3.2.1 Rivet Dimensions. Protruding and 100° and 78° flush head rivets shall conform to the dimensions given in Tables 2 and 4, respectively.

3.2.2 Application Data. Recommendations on the selection and application of protruding and 100° and 78° flush head rivets are given in Tables 3 and 5, respectively.

4. Inspection

Rivets shall be inspected to determine conformance with dimensional, mechanical, and performance requirements. Inspection shall be as agreed upon between manufacturer and purchaser.

Properly set rivet



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