



AEROSPACE STANDARD

AS7222™**REV. B**

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Superseding AS7222A

Aluminum Rivets, UNS A92117
2.5Cu - 0.3Mg (2117-T4)
Procurement Specification

FSC 5320

RATIONALE

This document has been determined to contain basic and stable technology which is not dynamic in nature.

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Documents

Standard Sharing Hub

1. SCOPE:

1.1 Type:

This procurement specification covers rivets made from an aluminum alloy designated as 2117-T4, solution treated. The following specification designations and their rivet coatings are covered:

AS7222	Rivets anodized per AMS 2470, chromic acid process
AS7222-1	Rivets anodized per AMS 2471, sulfuric acid process

1.2 Application:

Primarily for joining aluminum parts where rivets having 26 ksi minimum ultimate shear strength is adequate.

2. REFERENCES:

2.1 Applicable Documents:

The following publications form a part of this document to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order. In the event of conflict between the text of this document and references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

2.1.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2355	Quality Assurance Sampling and Testing of Aluminum Alloys and Magnesium Alloys, Wrought Products Except Forging Stock and Rolled, Forged, or Flash Welded Rings
AMS 2470	Anodic Treatment of Aluminum Alloys, Chromic Acid Process
AMS 2471	Anodic Treatment of Aluminum Alloys, Sulfuric Acid Process, Undyed Coating
AMS 2770	Heat Treatment of Wrought Aluminum Alloy Parts
AS125251 thru AS125400	Rivet - 100° Countersunk Head, Aluminum Alloy
AS125701 thru AS125850	Rivet - Universal Head, Aluminum Alloy

2.1.2 NAS Publications: Available from Aerospace Industries Association, 1250 Eye Street NW, Washington, DC 20005.

MIL-STD-1312-13	Fastener Test Methods, Method 13, Double Shear
MIL-STD-1312-20	Fastener Test Methods, Method 20, Single Shear

2.1.3 ASTM Publications: Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM B 565	Shear Testing of Aluminum Alloy Rivets and Cold Heading Wire and Rods
ASTM D 3951	Commercial Packaging

2.1.4 ASME Publications: Available from ASME, 22 Law Drive, Box 2900, Fairfield, NJ 07007-2900.

ASME Y14.5M-1982	Dimensioning and Tolerancing
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2.2 Definitions:

NON-CONFORMANCE: A departure from a specified requirement for any characteristic.

NON-CONFORMING UNIT: A unit of product that has one or more non-conformances.

PRODUCTION INSPECTION LOT: Shall be all finished parts of the same part number, made from a single heat of alloy, heat treated at the same time to the same specified condition, produced as one continuous run, and submitted for vendor's inspection at the same time.

3. TECHNICAL REQUIREMENTS:

3.1 Material:

The rivets shall be made from material conforming to the following:

3.1.1 Composition: Shall conform to the percentages by weight shown in Table 1, determined in accordance with AMS 2355.