ASME B18.18.2M-1994-SUPPLEMENT

[Supplement of ASME B18.18.2M-1987 (R1993)]

INSPECTION AND QUALITY ASSURANCE FOR HIGH-VOLUME MACHINE ASSEMBLY FASTENERS

AN AMERICAN NATIONAL STANDARD

The American Society of Mechanical Engineers

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Date of Issuance: August 30, 1996

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Supplement
to
ASME/ANSI B18.18.2M-1987(R1993)

The changes listed below apply to ASME/ANSI B18.18.2M-1987(R1993), Inspection and Quality Assurance for High-Volume Machine Assembly Fasteners. The revised Foreword and Roster are included in this Supplement in their entirety.

Page	Location	Change
iii	Foreword	Last paragraph added
v	Roster	Personnel of Subcommittee 18 updated
3	Para. 2.7	Add third sentence, shown in boldface, as follows:

Each lot of fasteners shall be subject to a final inspection. The final inspection is intended to verify lot identification, to check for mechanical property conformance and mixed stock, and to inspect designated characteristics for conformance to related specifications and engineering drawings. **Final inspection of any characteristic may be conducted at any stage of manufacturing provided the characteristic is not subject to change in any further manufacturing or processing operation.** Records of final inspection shall be maintained in accordance with para. 2.4. The requirements are given in Table 1, and destructive test requirements are given in Table 2. Sample sizes are then determined in accordance with Table 3.

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FOREWORD

(This Foreword is not part of ASME/ANSI B18.18.2M-1987.)

American National Standards Committee B18 for the standardization of bolts, screws, nuts, rivets, and similar fasteners was organized in March 1922 as Sectional Committee B18 under the aegis of the American Engineering Standards Committee (later the American Standards Association, then the United States of America Standards Institute and, as of October 6, 1969, the American National Standards Institute, Inc.) with the Society of Automotive Engineers and the American Society of Mechanical Engineers as joint sponsors.

Subcommittee 18 of Committee B18 was established in September 1978 to develop a document to cover the quality assurance provisions for internally and externally threaded metric fasteners and accessories or associated parts.

At the March 1979 meeting of Subcommittee 18, it was agreed that the quality assurance document should be circulated for subcommittee consideration as a proposed standard. Subcommittee acceptance of the content ensued and the document was approved by letter ballot to the American National Standards Committee B18 on March 21, 1980.

The standard was subsequently approved by the Secretariat and submitted to the American National Standards Institute for designation as an American National Standard; it was designated ANSI B18.18.2M-1982 and approved on September 14, 1982.

A periodic review of the standard, undertaken by the Subcommittee in 1985, resulted in agreement that the document be revised to allow it to be used for inch as well as metric products. This was done by deleting the word "metric" from the title as well as from each place in the standard where it would inhibit the use of the document for inch as well as metric products. By retaining the "M" in the designator, the standard can be used for both inch and metric products without having to change any references made. A proposal containing these changes, as well as editorial corrections, was prepared and balloted by letter ballot to ASME Committee B18. Following approval by ASME, the proposal was submitted to the American National Standards Institute and designated an American National Standard on January 16, 1987.

In response to requests in 1993, Subcommittee 18 reviewed the standard to address the possibility of performing the "final inspection" in stages through the manufacturing process. This review resulted in Subcommittee approval and issuance of a supplement to ASME B18.18.2M-1987(R1993). This Supplement adds a sentence to paragraph 2.7 that permits final inspection to be performed at any stage of manufacture as long as the characteristics are not subject to subsequent change.

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Standardization of Bolts, Nuts, Rivets, Screws, Washers, and Similar Fasteners

(The following is the roster of the Committee at the time of approval of this Standard.)

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