D-15-11

ANSI/ASME B18.7.1M-1984
30 January 1985

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Title of Document:	Rivet, Semi-Tubular, General Purpose-Metric
Document No.	ANSI/ASME B18.7.1M-1984
Date of Specific Issue Adopted:	24 July 1984
Releasing Industry Group:	The American Society of Mechanical Engineers

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AN AMERICAN NATIONAL STANDARD

Metric General Purpose Semi-Tubular Rivets

ANSI/ASME B18.7.1M - 1984

Government Key Words:
Rivet, Semi-Tubular,
General Purpose — Metric

SPONSORED AND PUBLISHED BY

THE AMERICAN SOCIETY OF MECHANICAL ENGINEERS

United Engineering Center 345 East 47th Street New York, N. Y. 10017

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Date of Issuance: December 31, 1984

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FOREWORD

(This Foreword is not part of ANSI/ASME B18.7.1M-1984.)

ASME Standards Committee B18, Subcommittee 7, has met periodically since 1979 to arrive at a metric standard to serve as a companion to ANSI B18.7. This Standard covers only oval head semi-tubular rivets with straight holes. The Committee has declared its intent to expand the scope of the standard to include other head styles, tapered holes, full tubular rivets, and rivet caps as their use in metric dimensions becomes apparent. These other styles of rivets, although not included here, are available from manufacturers, and the dimensions in this Standard should be the basis for further development.

Because semi-tubular rivets are used in automatic assembly machines, the concentricity of the outside edge of the head to the rivet shank is an important functional attribute. On a low oval head rivet, the axis of the head is very difficult to find, and therefore the true head position method of measuring concentricity was not used in this Standard.

This proposal was approved by letter ballot of the B18 Main Committee on June 24, 1983. Following acceptance by ASME, this proposal was referred to the American National Standards Institute for designation as an American National Standard. This was granted on July 24, 1984.

Suggestions for improving this Standard will be welcome and should be sent to the American Society of Mechanical Engineers, United Engineering Center, 345 East 47th Street, New York, New York 10017.

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

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ANSI/ASME B18.7.1M-1984
AN AMERICAN NATIONAL STANDARD

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METRIC GENERAL PURPOSE SEMI-TUBULAR RIVETS

1 INTRODUCTORY NOTES

1.1 Scope

1.1.1 This Standard covers the general and dimensional data for oval head semi-tubular rivets for use in general purpose applications. The products described are suitable for joining metallic and nonmetallic materials or combinations thereof. Although these products are suitable for general purpose assembly, other special purpose types are available to satisfy particular requirements, and manufacturers should be consulted for special requirements.

1.1.2 The inclusion of dimensional data in this Standard is not intended to imply that all of the products described are stock production sizes. Consumers are requested to consult with manufacturers concerning availability of products.

1.1.3 Metric general purpose semi-tubular rivets purchased for government use shall conform to this Standard and, additionally, to the requirements of Appendix I.

1.2 Types of Rivets. The rivets specified in this Standard include the following.

1.2.1 Semi-Tubular Rivets. Semi-tubular rivets are available in the head styles listed in Section 2 and shall have straight holes normally produced by extruding or drilling.

1.2.2 (Reserved for other types.)

1.3 Options. Options, where specified, shall be at the discretion of the manufacturer unless otherwise agreed upon by the manufacturer and the purchaser.

1.4 Dimensions. All dimensions in this Standard are given in millimeters unless otherwise stated.

1.5 Related Standards. Standards in this series for small solid rivets, large rivets, and other related products are published under separate cover.

2 GENERAL DATA FOR SEMI-TUBULAR RIVETS

2.1 Heads

2.1.1 Because the heads of these rivets are not machined or trimmed, the circumference may be somewhat irregular and the edges may be rounded or flat.

2.1.2 The bearing surface of oval head rivets shall be perpendicular to the axis of the rivet shank within 2 deg.

2.1.3 The rivet head and the rivet shank shall be concentric with 11% of the nominal shank diameter on the basis of full indicator movement (FIM).

2.2 Underhead Fillets. Oval head rivets shall be furnished with a fillet of not less than 0.1 mm under the head; however, the radius of the fillet shall not exceed the values specified in Table 2.

2.3 Length

2.3.1 Measurement. The length of oval head rivets shall be measured parallel to the axis of rivet from the underside of the head to the extreme end of the rivet.

2.3.2 Length Increments. The minimum lengths and increments applicable to longer lengths shall be as specified in Table 1.

2.3.3 Tolerance on Length. The tolerance on length of rivets shall be as specified in Table 1.

2.4 Hole Depth

2.4.1 Hole depth shall be measured parallel to the axis of the rivet from the extreme end of the rivet to the intersection of the diameter of the hole with contour at bottom of hole. The hole depth to extreme point on bottom contour of hole shall not be greater than the actual shank length of the rivet.

2.4.2 The tolerance on hole depth shall be as specified in Table 2.

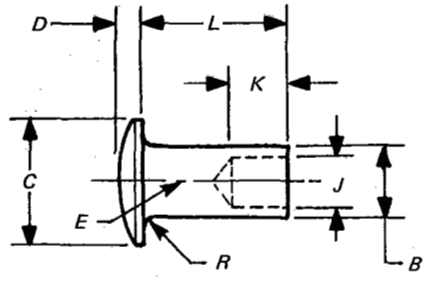
2.5 Material. Semi-tubular rivets are made from low carbon steel (0.1% carbon or less), commercial yellow

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TABLE 1 LENGTH INCREMENTS AND LENGTH TOLERANCES FOR SEMI-TUBULAR RIVETS

Nominal Size, mm	Length Increment, mm	Minimum Nominal Rivet Length, *L*, mm	Tolerance on Length		
			For Nominal Lengths		
			Up to and Including 4 Times Shank, diam., mm	Over 4 Times Shank Diam. and up to and Including 8 Times Shank, diam., mm	Over 8 Times Shank, diam., mm
1.6	0.5	2.00	±0.18	±0.20	±0.25
2.0	0.5	2.00	±0.18	±0.20	±0.25
2.5	0.5	2.00	±0.18	±0.20	±0.25
3.0	0.5	2.50	±0.18	±0.25	±0.38
3.5	1.0	3.00	±0.25	±0.30	±0.38
4.0	1.0	3.00	±0.25	±0.30	±0.38
5.0	1.0	4.00	±0.25	±0.30	±0.38
6.0	2.0	5.00	±0.25	±0.38	±0.50
7.0	2.0	6.00	±0.25	±0.38	±0.50
8.0	2.0	6.00	±0.25	±0.38	±0.50

GENERAL NOTE: The dimensions shown below relate to the respective values shown in Tables 1 and 2.



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GENERAL NOTE: The dimensions shown below relate to the respective values shown in Tables 1 and 2.

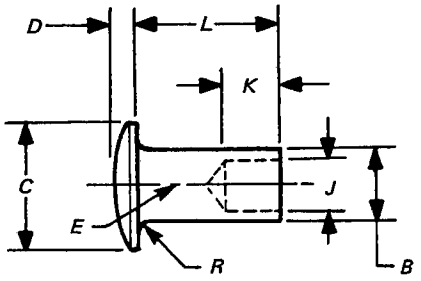


TABLE 2 TOLERANCE ON HOLE DEPTH

Nominal Length	Body Size, *B*	Head Diam., *C*	Head Thickness, *D*	Head Radius Reference, *E*	Underhead Radius Max., *R*	Hole Diam., *J*	Hole Depth, *K*	Work Hole Diam.
1.6	1.56/1.64	2.75/3.01	0.43/0.53	3.09	0.15	1.15/1.25	1.20 ± 0.15	1.71
2.0	1.95/2.05	3.47/3.73	0.52/0.68	3.83	0.20	1.45/1.55	1.50 ± 0.15	2.14
2.5	2.45/2.55	4.37/4.63	0.67/0.83	4.84	0.25	1.83/1.93	1.88 ± 0.20	2.67
3.0	2.94/3.06	5.27/5.53	0.80/1.00	5.78	0.32	2.20/2.30	2.25 ± 0.20	3.21
3.5	3.44/3.56	6.17/6.43	0.92/1.18	6.80	0.38	2.58/2.68	2.63 ± 0.20	3.75
4.0	3.93/4.07	7.07/7.33	1.07/1.33	7.81	0.43	2.95/3.05	3.00 ± 0.20	4.28
5.0	4.92/5.08	8.85/9.15	1.37/1.63	9.74	0.53	3.70/3.80	3.75 ± 0.20	5.35
6.0	5.91/6.09	10.62/10.98	1.62/1.98	11.72	0.65	4.43/4.57	4.50 ± 0.20	6.42
7.0	6.90/7.10	12.42/12.78	1.92/2.28	13.68	0.76	5.18/5.32	5.25 ± 0.38	7.49
8.0	7.90/8.10	14.20/14.60	2.22/2.58	15.71	0.88	5.93/6.07	6.00 ± 0.38	8.56

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brass, copper, aluminum, stainless steel, or other materials as agreed to by the manufacturer and the purchaser.

The following raw materials are in common use.

Steel (AISI)	Brass	Aluminum (Alum. Assoc.)[1]
C1006	CDA260	5052-H32
C1008	CDA270	5056-H32
		1100-H14
		2117-H15

Copper	Stainless Steel (AISI)	Monel
CDA102	Type 430	AMS 7233
CDA110	Series 300 (302, 305)	

NOTE:
(1) Rivets made from Type 2117 aluminum are heat treated and supplied in the T-4 condition.

2.6 Finish. Unless otherwise specified, rivets shall be supplied with a natural (as-processed) finish, unplated or uncoated. Many different types of plating or protective coatings may be specified. The following types are in common use. Caution should be used in selecting a finish to assure that it is compatible with the use of the end products.

Zinc, Nickel, Brass, Chromium, Copper, Anodized Aluminum, Cadmium, Tin

NOTE: Nickel and chromium finishes are very hard, and therefore will have a tendency to flake off the end of the rivet when it is set by the user.

2.7 Workmanship. The rivets shall be free from all burrs, seams, or other imperfections that may impair their usability.

2.8 Designation

2.8.1 Semi-tubular rivets shall be designated by the following data in the sequence shown: nominal size; length (in millimeters); product name; material; and protective finish, if required.

EXAMPLE:
ANSI/ASME B18.7.1M, 3 mm X 4 mm Semi-Tubular Rivet, Oval Head, Steel, Zinc Plated

2.8.2 The government part numbering system for metric semi-tubular rivets is given in Appendix I. This system may be used by any user needing a definitive part numbering system.

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APPENDIX I

GOVERNMENT STANDARD ITEMS AND PART NUMBERING SYSTEM

(This Appendix is not an integral part of ANSI/ASME B18.7.1M-1984 and is included for information purposes only.)

NOTE: The government encourages the general use of this Appendix to achieve maximum parts standardization.

This Appendix establishes the standard items for government application, selected from the possible variations of items within the scope of the standard, and provides a part numbering system for identification and application in engineering documents.

The following variations are standard:

(*a*) Nominal Size and Length Combinations – as specified on last page of this Appendix

(*b*) Head Type – as coded in Part Numbering System

(*c*) Material (steel, brass, aluminum, copper or monel – as coded in Part Numbering System

(*d*) Finish (plain, cadmium, black oxide, nickel, anodized) – as coded in Part Numbering System.

The part number shall consist of the following element codes in the order shown:

(*a*) Document Identifier – ANSI Standard number less decimal points

(*b*) Material and Finish

(*c*) Head Type

(*d*) Nominal Size

(*e*) Nominal Length.

NOTE: The Part Numbering System may also be used for non-standard size and length combinations.

Quality Assurance Provisions. Quality assurance provisions shall be in accordance with FF-R-556, Rivet, Solid, Small; Rivet Tubular, Small; Flat Washer (Burr); Cap, Rivet; General Purpose.

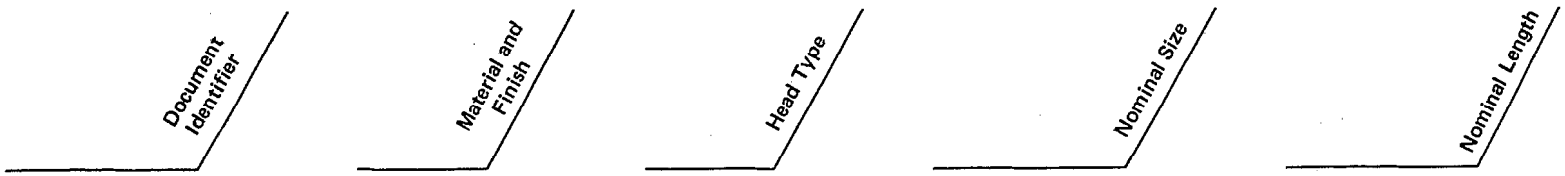
Packaging. Packaging shall be in accordance with PPP-H-1581, Hardware (Fasteners and Related Items) Packaging of.

Table 1 of this Standard is to be used for selection of standard sizes for government use.

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PART NUMBERING SYSTEM COVERING STANDARD ITEMS FOR GOVERNMENT USE

NOTE: THE GOVERNMENT ENCOURAGES THE GENERAL USE OF THIS SYSTEM TO ACHIEVE MAXIMUM PARTS STANDARDIZATION.



Material and Finish Code	
A = Steel, composition C1006 through C1010 (UNS G10060 through G10100), with cadmium plating per QQ-P-416, Type II, Class 2 (7.6 μm thickness)	D = Aluminum, Type AA5056-H32 (UNS A95056)
B = Brass, CDA Type 260 or 270 (UNS C26000 or C27000), with black oxide finish per MIL-F-495	E = Aluminum, Type AA2117-H15 (UNS A92117), heat treated, supplied in T-4 condition, and anodized per MIL-A-8625
C = Brass, CDA Type 260 or 270 (UNS C26000 or C27000), with nickel plating per QQ-N-290, Class 1, Grade F (10 μm thickness)	F = Copper, CDA Type 102 (UNS C10200)
	G = Monel (400) per AMS 7233 (UNS N04400)

Head Type Code
P = Oval

EXAMPLE: B1871DP020165 indicates a rivet, semi-tubular, general purpose—metric, made of aluminum, Type AA5056-H32, oval head, 2 mm nominal size, and 16.5 mm length.

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AMERICAN NATIONAL STANDARDS FOR BOLTS, NUTS, RIVETS, SCREWS, WASHERS, AND SIMILAR FASTENERS

Small Solid Rivets B18.1.1-1972 (R1983)
Large Rivets B18.1.2-1972 (R1983)
Metric Small Solid Rivets B18.1.3M-1983
Square and Hex Bolts and Screws B18.2.1-1981
Square and Hex Nuts B18.2.2-1972 (R1983)
Metric Hex Cap Screws B18.2.3.1M-1979
Metric Formed Hex Screws B18.2.3.2M-1979
Metric Heavy Hex Screws B18.2.3.3M-1979
Metric Hex Flange Screws B18.2.3.4M-1984
Metric Hex Bolts B18.2.3.5M-1979
Metric Heavy Hex Bolts B18.2.3.6M-1979
Metric Heavy Hex Structural Bolts B18.2.3.7M-1979
Metric Hex Lag Screws B18.2.3.8M-1981
Metric Heavy Hex Flange Screws B18.2.3.9M-1984
Metric Hex Nuts, Style 1 ..... B18.2.4.1M-1979
Metric Hex Nuts, Style 2 ..... B18.2.4.2M-1979
Metric Slotted Hex Nuts B18.2.4.3M-1979
Metric Hex Flange Nuts B18.2.4.4M-1982
Metric Hex Jam Nuts B18.2.4.5M-1979
Metric Heavy Hex Nuts B18.2.4.6M-1979
Socket Cap, Shoulder and Set Screws — Inch Series B18.3-1982
Socket Head Cap Screws (Metric Series) B18.3.1M-1982
Metric Series Hexagon Keys and Bits B18.3.2M-1979
Hexagon Socket Head Shoulder Screws: Metric Series B18.3.3M-1979
Hexagon Socket Button Head Cap Screws: Metric Series B18.3.4M-1979
Hexagon Socket Flat Countersunk Head Cap Screws (Metric Series) B18.3.5M-1983
Metric Series Hexagon Socket Set Screws B18.3.6M-1979
Round Head Bolts (Inch Series) B18.5-1978
Metric Round Head Short Square Neck Bolts B18.5.2.1M-1981
Metric Round Head Square Neck Bolts B18.5.2.2M-1982
Wood Screws B18.6.1-1981
Slotted Head Cap Screws, Square Head Set Screws, and Slotted Headless Set Screws B18.6.2-1972 (R1983)
Machine Screws and Machine Screw Nuts (M-4) B18.6.3-1972 (R1983)
Thread Forming and Thread Cutting Tapping Screws and Metallic Drive Screws (Inch Series) B18.6.4-1981
General Purpose Semi-Tubular Rivets, Full Tubular Rivets, Split Rivets and Rivet Caps B18.7-1972 (R1980)
Metric General Purpose Semi-Tubular Rivets B18.7.1M-1984
Clevis Pins and Cotter Pins B18.8.1-1972 (R1983)
Taper Pins, Dowel Pins, Straight Pins, Grooved Pins, and Spring Pins (Inch Series) B18.8.2-1978
Plow Bolts B18.9-1958 (R1977)
Track Bolts and Nuts B18.10-1982
Miniature Screws B18.11-1961 (R1983)
Glossary of Terms for Mechanical Fasteners B18.12-1962 (R1981)
Screw and Washer Assemblies — Sems B18.13-1965 (R1983)
Forged Eyebolts B18.15-1969
Mechanical and Performance Requirements for Prevailing-Torque Type Steel Metric Hex Nuts and Hex Flange Nuts B18.16.1M-1979
Torque-Tension Test Requirements for Prevailing-Torque Type Steel Metric Hex Nuts and Hex Flange Nuts B18.16.2M-1979
Dimensional Requirements for Prevailing-Torque Type Steel Metric Hex Nuts and Hex Flange Nuts B18.16.3M-1982
Wing Nuts, Thumb Screws, and Wing Screws B18.17-1968 (R1983)
Inspection and Quality Assurance for General Purpose Metric Fasteners B18.18.1M-1982
Inspection and Quality Assurance for High-Volume Machine Assembly Metric Fasteners B18.18.2M-1982
Inspection and Quality Assurance for Special Purpose Metric Fasteners B18.18.3M-1982
Inspection and Quality Assurance for Specialized Engineered Applications — Metric Fasteners B18.18.4M-1982
Lock Washers B18.21.1-1972 (R1983)
Metric Plain Washers B18.22M-1981
Plain Washers B18.22.1-1965 (R1981)
Beveled Washers B18.23.1-1967 (R1975)

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