RIVETS, SNAP HEAD, STEEL, HOT CLOSING (6 mm – 12 mm)

1.0 DESIGNATION:

A snap head rivet of diameter 6mm, length 35 mm and made of steel shall be designated as:

1.1 On Drawings:

i) Material specification column   : AA7174014

ii) Description Column   : RIVET SNAP 6X35–ST

1.2 On Indents: Rivet Snap Head 6 X35 AA7174014

1.3 For issuing enquiries and on purchase orders:

While issuing enquiries and purchase orders, delete BHEL standard number from the above description and add the information given under clause 2.0

2.0 COMPLIANCE WITH STANDARDS:

2.1 Dimensions, Tolerances and General Requirements

As per IS:2155–1982

2.2 Material: Steel as specified in IS:2155

2.3 Protective Coating:

Rivet shall be supplied in a well cleaned condition and suitable protected against oxide formation

2.4 Finish: Plated as specified in BHEL order.

Revisions: Clause No. 31.9.0 of MOM of MRC-F			**APPROVED:** INTERPLANT MATERIAL RATIONALISATION COMMITTEE – MRC(F)		
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3.0   NOTE:

3.1   Length and diameter combination (refer to Table-1 on page 3 of 3) between the bold line should only be used.

3.2   Rivets to this standard would be un-plated. Divisions wishing to have plated washers would have to get them plated.

3.3   Weights given in the standard are for general reference only and are not meant for commercial transactions

3.4   These cold forged steel rivets are meant for hot closing.

3.5   For cold forged snap head steel rivets meant for cold closing (1.6–5mm) refer to BHEL standard AA7174016

3.6   When the fasteners are to be tested with in BHEL, sampling and acceptance plan shall be as per IS:10102.

4.0   Referred Standards (Latest publications including amendment):

1)   IS:2155   2)   IS:10102   3)   AA7174016

EXPLANATORY NOTE

The following changes have been made in this revision:

-    Cl.3.6 Sampling and acceptance shall be as per IS:10102 in place of IS:6821 and the table given under the clause is deleted.

-    A new clause 4.0 Referred standards is added.

-    Four pages made to three pages.

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$t = 2IT14$ for $d \leq 8$
$t = 2IT15$ for $d > 8$

Note:
1. Corporate sub code numbers are shown in Table 1.
2. Weights have been shown in kg per 1000Nos.

All dimensions are in 'mm'

EDGE ROUNDED OR FLAT

TABLE – 1

Diameter d			d_s	d_k	k	r	r_k	b
Nom.	Max.	Min.	Min.	Nom.	Nom.	Max.	≈	Max.
6	6.15	5.85	5.82	9.6	4.2	0.3	5.7	0.3
8	8.15	7.85	7.76	12.8	5.6	0.4	7.5	0.3
10	10.3	9.7	9.4	16.0	7.0	0.5	8.0	0.3
12	12.3	11.7	11.3	19.2	8.4	0.6	9.5	0.4

Length (l) — Tol. +0.5 for $l \leq 10$, 0; +1.0 for $10 < l \leq 20$, 0; +1.5 for $l > 20$, 0

	12	14	16	18	20	22	24	26	28	30	35	40	45	50	55	60	65
Sub Code			127					135			089						
Weight			5.6					8.13			10.4						
Sub Code													151				
Weight																	
Sub Code																	
Weight																	
Sub Code																	
Weight																	