
**RIVET - TITANIUM, COUNTERSUNK HEAD,
ALUMINIUM FINISH**

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1 - SCOPE AND FIELD OF APPLICATION


This standard specifies the dimensions, tolerances, required characteristics and the masses of a titanium rivet, countersunk head, aluminium finish.

2 - REFERENCES

A/DET 0012 : Process specification - Aluminium base protection for fasteners.
EN 2424 : Aerospace series - Marking of aerospace products.
CM 043 : Rivets wires and rivets in unalloyed titanium (T40) with diameter less than or equal to 4,8 mm.

3 - TERMINOLOGY

Not applicable.

<p style="text-align: center;">AIRBUS France ESW-S</p>  <p style="text-align: center;">D. MALLARD</p>	<p style="text-align: center;">© - AIRBUS France – August 2001</p>	<p style="text-align: center;"><u>WRITER :</u> ESW-T J. CHAMBERT</p>
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4 - REQUIRED CHARACTERISTICS

4.1 - Configuration, dimensions, tolerances, mass

4.1.1 - Configuration shall be in accordance with the figure.

4.1.2 - Dimensions shall be in accordance with the figure, Table 1 and Table 2.

4.1.3 - Tolerances shall be in accordance with the figure and Table 1.

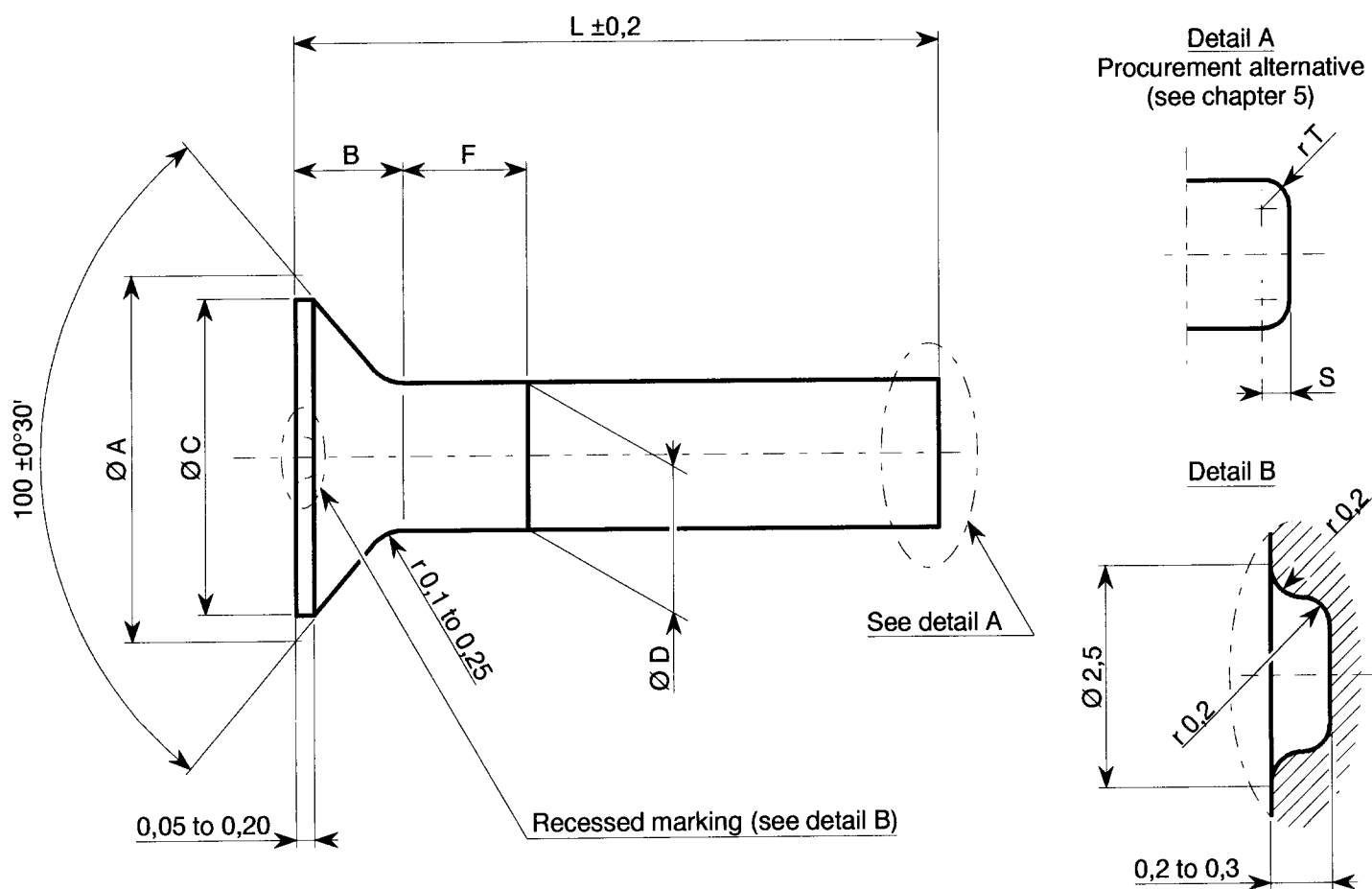
Coaxial tolerance of the tapered head surface in relation to the stem : 0,25 mm max. (TIR).

4.1.4 - Mass shall be in accordance with Table 1.

4.2 - Material, finish

4.2.1 - Material shall be in accordance with Table 3.

4.2.2 - Finish shall be in accordance with Table 3.



Note : Maximum head inclination in relation to the stem : $0^\circ 30'$.

Dimensions in mm.

Figure - Configuration, dimensions, tolerances

Table 1 - Dimensions, tolerances, mass

ITEM CODE No.	NOMINAL Ø	Ø A		B approx.	Ø C		Ø D	
		Max.	Min.		Max.	Min.	Max.	Min.
24	2,4	4,29	4,14	0,76	4,17	3,66	2,46	2,36
32	3,2	5,38	5,23	0,88	5,26	4,75	3,25	3,15
36	3,6	6,10	5,94	1,02	5,98	5,46	3,65	3,55
40	4,0	6,90	6,68	1,17	6,78	6,20	4,04	3,94
48	4,8	8,59	8,35	1,55	8,47	7,87	4,83	4,73
56	5,6	9,95	9,70	1,78	9,83	9,22	5,63	5,53

ITEM CODE No.	NOMINAL Ø	F *	S	r T	MASS (g) (installed rivet)
24	2,4	2,5	0,58	0,73	0,12
32	3,2		0,78	0,99	0,25
36	3,6		0,88	1,11	0,36
40	4,0		0,99	1,24	0,50
48	4,8	3,0	1,19	1,49	0,82
56	5,6	3,5	1,37	1,75	1,20

* The F size represents the minimum length where "D" tolerances are applicable.

Dimensions in mm.

Table 2 - Dimensions

ITEM CODE No.	Standardized length L for each diameter (for information)																			
	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25
24	+	+	+	+	+	+	+													
32	+	+	+	+	+	+	+	+	+	+										
36			+	+	+	+	+	+	+	+	+	+	+							
40			+	+	+	+	+	+	+	+	+	+	+							
48					+	+	+	+	+	+	+	+	+	+	+	+	+			
56					+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+

Dimensions in mm.

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Table 3 - Material, finish

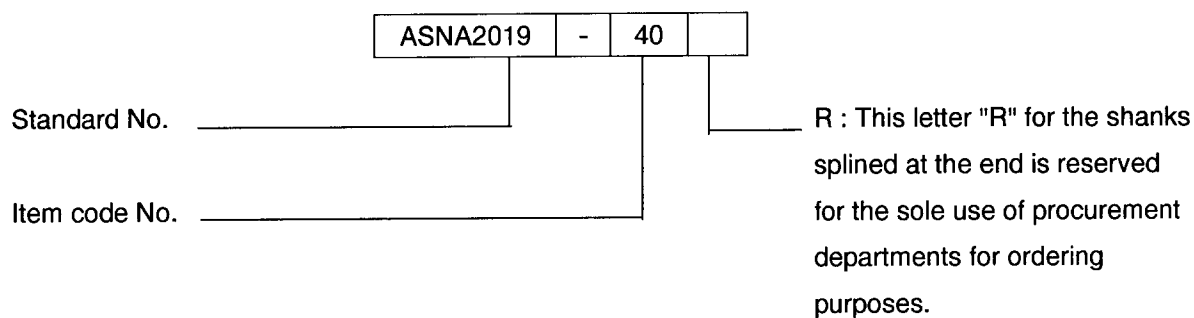
MATERIAL	FINISH
Titanium T40	Aluminium as per A/DET 0012

5 - DESIGNATION

Example of part number identification to be used on drawing schedules :

ASNA2019-40 , Rivet

Example of part number construction :



6 - MARKING

Parts shall be marked as per EN 2424, categories G.

7 - TECHNICAL SPECIFICATION

CM 043 (except finish).

8 - MANUFACTURERS

Refer to the list of qualified manufacturers and products.

AMENDMENT RECORD SHEET

Issue	Modified paragraph	Modification summary	Justification
A.03.81		New standard.	
B.01.82			
C.10.83			
D.01.87		Amended standard.	
		In designation, Note added for procurement departments.	
E.06.90		Ø C added.	Following note JB74
		In figure, thickness of cylindrical head part modified : 0,05 to 0,15 mm changed to 0,05 to 0,20 mm.	
F.10.96		ASN-A2019-40 changed to ASNA2019-40.	In accordance with written rules.
G.08.01		Standard fully amended.	TF3 - WG1
		Table 2 added for standardized lengths.	item 19-28

NOTE : Modification to the last standard issue are indicated by a vertical line in the margin.