

**Rivet-titanium alloy
100° reduced flush head-50 ksi_{fsu}
Shear version**

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1 Scope

This standard specifies the dimensions, tolerances of titanium–columbium rivet.

2 Normative References

AMS4982	Titanium alloy bars and forgings, 55Ti–CB
EN2424	Marking of aerospace products
ISO8080	Aerospace, anodic treatment of titanium and titanium alloys
MIL–R–5674	Procurement specification for titanium–columbium rivet

3 Requirements

3.1 Configuration – Dimensions – Tolerances – Mass

Configuration shall be accordance with the figure.

Dimensions, tolerances and mass shall conform with the figure 1 and 2 and the table 1 and 2

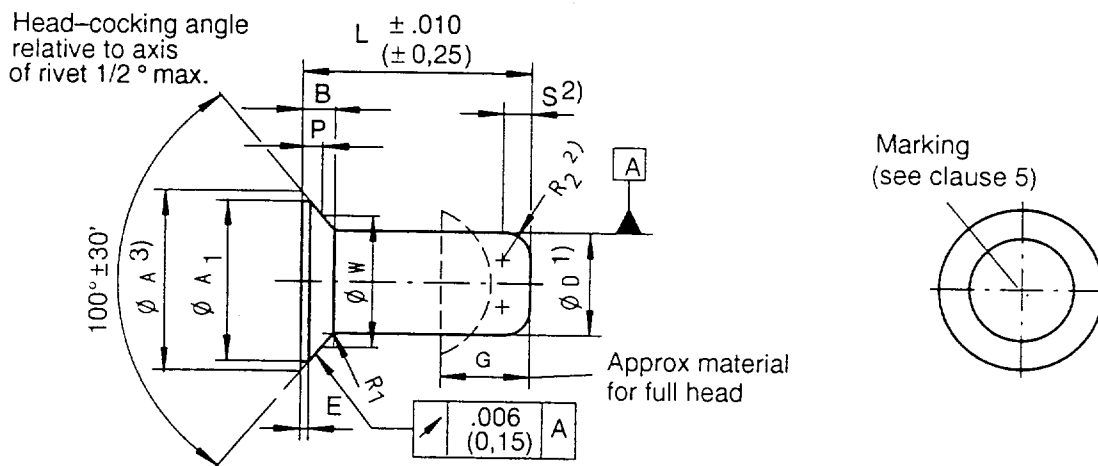


Figure 1 – Configuration

- 1) .001 (0,025) shank diameter increase is permissible within .10 (2,54) of the base of the head.
- 2) Chamfered ends with a radius to the R_1 dimensions or a 20° chamfer to the "S" dimension.
- 3) Maximum head diameters are to theoretical sharp corners as measured by projection.

Table 1 ¹⁾

Dimensions in inches (millimetres)

Dia dash–no. 2)		– 3	– 4	– 5
D = Nominal dia	$\begin{matrix} +.003 \\ -.001 \\ (+0,080) \\ (-0,025) \end{matrix}$.094 (2,388)	.125 (3,175)	.156 (3,962)
	$\begin{matrix} \pm .004 \\ (\pm 0,102) \end{matrix}$.144 (3,656)	.192 (4,877)	.243 (6,172)
A ₁	min.	.126 (3,200)	.174 (4,420)	.225 (5,715)
B	Ref.	.021 (0,533)	.028 (0,711)	.037 (0,940)
G	Ref.	.141 (3,581)	.188 (4,775)	.234 (5,943)

(continued)

Table 1 ¹⁾ (concluded)

		Dimensions in inches (millimetres)		
Dia dash-no. ²⁾		- 3	- 4	- 5
P	min.	.0089 (0,226)	.0106 (0,269)	.0153 (0,389)
	max.	.0123 (0,312)	.0141 (0,358)	.0189 (0,480)
R ₁	max.	.010 (0,254)	.010 (0,254)	.010 (0,254)
R ₂	± .010 (± 0,254)	.029 (0,737)	.039 (0,991)	.049 (1,244)
S	± .010 (± 0,254)	.023 (0,584)	.031 (0,787)	.039 (0,991)
E	max.	.006 (0,152)	.006 (0,152)	.006 (0,152)
W	+ .0002 (+ 0,01)	.119 (3,023)	.163 (4,140)	.203 (5,156)
1) All dimensions apply before application of lubrication				
2) Dash-no. indicates nom. dia in 1/32 inch increments				

Table 2

Length dash-no. ¹⁾	Dimensions in inches (millimetres)					
	-3		-4		-5	
	L ± .010 (± 0,254)	Mass lbs/1000pcs (kg/1000pcs)	L ± .010 (± 0,254)	Mass lbs/1000pcs (kg/1000pcs)	L ± .010 (± 0,254)	Mass lbs/1000pcs (kg/1000pcs)
-2	.125 (3,175)	.207 (0,094)	-	-	-	-
-3	.188 (4,763)	.298 (0,135)	.188 (4,763)	.536 (0,243)	.188 (4,763)	.865 (0,392)
-4	.250 (6,35)	.389 (0,176)	.250 (6,35)	.699 (0,317)	.250 (6,35)	1.118 (0,507)
-5	.313 (7,938)	.480 (0,218)	.313 (7,938)	.862 (0,391)	.313 (7,938)	1.371 (0,622)
-6	.375 (9,525)	.571 (0,259)	.375 (9,525)	1.025 (0,465)	.375 (9,525)	1.624 (0,737)
-7	.438 (11,113)	.662 (0,299)	.438 (11,113)	1.188 (0,539)	.438 (11,113)	1.877 (0,851)
-8	.500 (12,700)	1.412 (0,640)	.500 (12,700)	1.351 (0,613)	.500 (12,700)	2.130 (0,966)
-9	.563 (14,288)	1.574 (0,714)	.563 (14,288)	1.514 (0,687)	.563 (14,288)	2.383 (1,081)
-10	.625 (15,875)	1.739 (0,789)	.625 (15,875)	1.845 (0,837)	.625 (15,875)	2.636 (1,195)
1) Dash-no. indicates length in 1/16 inch increments						

3.2 Material

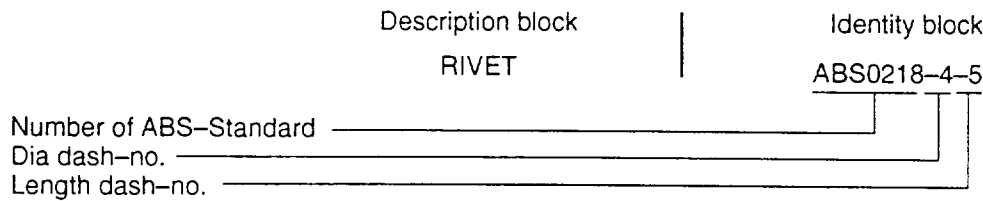
Titanium–columbium alloy 45CB per AMS4982. Heat treat; anneald per AMS4982

3.3 Surface treatment

Finish; anodized per ISO8080

4 Designation

Example:



5 Marking

5.1 Material identification

Symbol on the head in accordance with figure 2

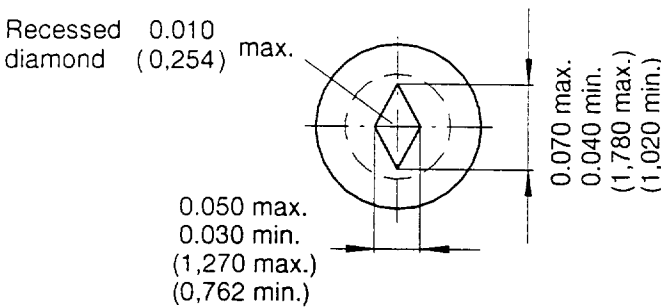


Figure 2

5.2 Manufacturer's identification

EN2424F to be depressed on rivet heads with a shank diameter .125 (3,175) and larger.

6 Technical specification

The rivets shall conform to the requirements of MIL–R–5674 except for the finish as stated