

FLAT HEAD RIVETS

Steel

REQUIREMENTS

Material

Steel VSS235NA+U STD 311-0009.

C max = 0,20 %.

Hardness: See heading "Hardness measuring".

Surface treatment

See table.

Others

Free from burrs, sharp edges and other defects which may lessen the usability.

The head of the rivet shall be marked with the manufacturer's designation.

Applies to shank as well as rivet head:

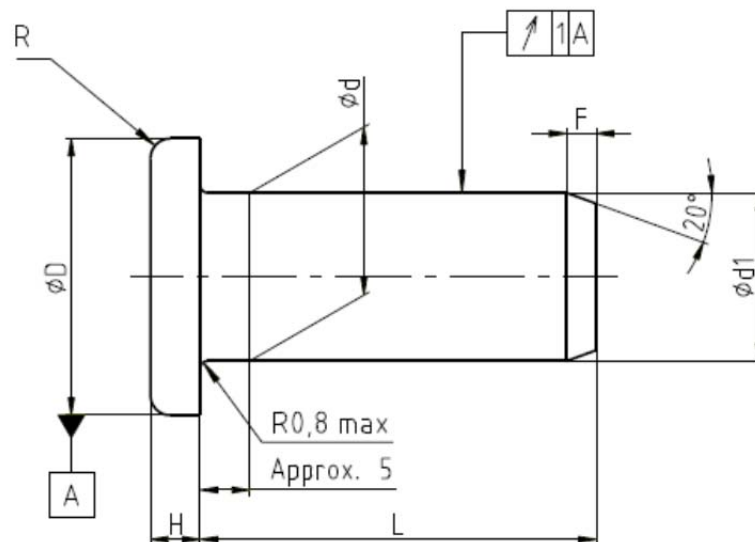
Grain size, the average diameter size shall be 20-60 μm (ISO-index G = 8-5).

The biggest grain may be max. 80 μm .

Grain size shall be determined as per STD 1013,141.

Symbols, designations and general drawing methods STD 101-0005.

Dimensions



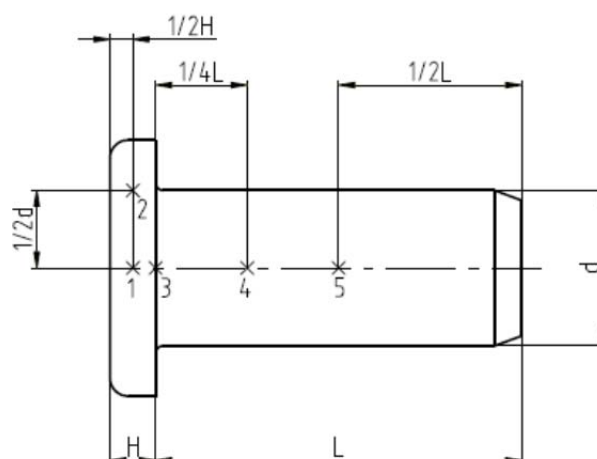
d	nom	15	17
	max	15,2	17,2
	min	14,8	16,8
d1	min	14,5	16,5
D		25	28
H	max	3	5,5
	min	4	4,5
F		4	4
R		2	2
L		Surface	Part No.
nom	min	treatment	
22,5	22		2)
26,5	26		3)
28	27,5	3)	1075083 P02
	28,5	1075029 P02	1075031 P02
36	35,5	3)	1075030 P02
60	59,5	3)	1075032 P02
	60,5	1070763 P02	

2) Electro-zincplated Fe/Zn 12 C₂ STD 5732,105. Part No. 1075083 is valid for USA only.
Part number 1075083 must not be used without over painting.

3) Electro-zincplated Fe/Zn-Fe 15 C₄ STD 5732,104
alt. Treated Y 2000-3, electroplated, colour black, STD 121-0004.

HARDNESS MEASURING

Hardness shall be measured after annealing.



Hardness on head, points 1 and 2: HV₃₀ = 130 – 150 (HB 120 – 140).

Hardness on rivet shank, points 3, 4 and 5: HV₃₀ = 150 – 180 (HB 140 – 170).