

इंटरनेट

मानक

Disclosure to Promote the Right To Information

Whereas the Parliament of India has set out to provide a practical regime of right to information for citizens to secure access to information under the control of public authorities, in order to promote transparency and accountability in the working of every public authority, and whereas the attached publication of the Bureau of Indian Standards is of particular interest to the public, particularly disadvantaged communities and those engaged in the pursuit of education and knowledge, the attached public safety standard is made available to promote the timely dissemination of this information in an accurate manner to the public.

“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 6836 (1973): Hand Snaps and Set-ups for Solid Rivets
[PGD 6: Earth, Metal And Wood Working Hand Tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

BLANK PAGE



AMENDMENT NO. 1 JUNE 1976

TO

IS:6836-1973 SPECIFICATION FOR HAND
SNAPS AND SET-UPS FOR SOLID RIVETS

Corrigendum

(Page 1, clause 2.1, Table, row 7,
col 9) - Substitute '5.0' for '3.0.'

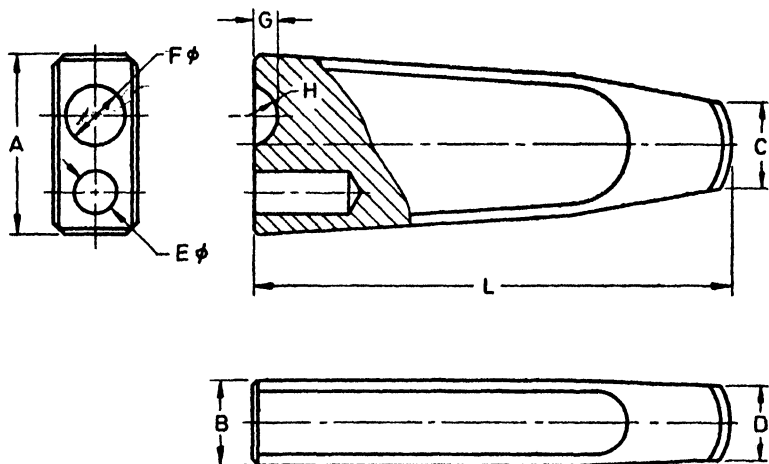
(EDC 12)

Reprography Unit, ISI, New Delhi



Indian Standard
SPECIFICATION FOR
HAND SNAPS AND SET-UPS
FOR SOLID RIVETS

1. **Scope** — Covers the requirements for hand snaps and set-ups for driving and setting of rivets.
2. **Dimensions**
- 2.1 *Combination Snaps and Set-Ups, Type A*



All dimensions in millimetres.

Nominal Size <i>d</i> *	A	B	C	D	E	F	G	H	L
1.6	12	5	5	4	2.1	2.5	1.0	1.3	100
2	14	5	5	4	2.5	3.2	1.3	1.6	100
2.5	17	6	6	5	3.0	4.0	1.5	2.0	100
3	19	8	8	6	3.5	4.8	1.9	2.4	100
4	24	9	9	8	4.5	6.3	2.5	3.2	100
5	29	12	12	10	6.0	7.9	3.2	4.0	125
6	33	15	15	12	7.0	9.5	3.8	3.0	125
8	42	19	19	16	9.0	12.6	5.0	6.5	125
10	47	22	22	19	11.0	15.8	6.3	8.0	125

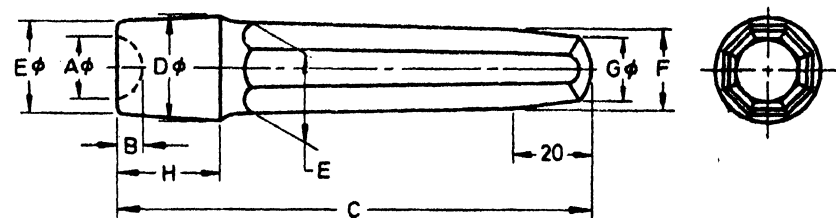
**d* = diameter of rivet.

Adopted 13 February 1973

© May 1973, ISI

Gr 2

2.2 Snaps, Type B

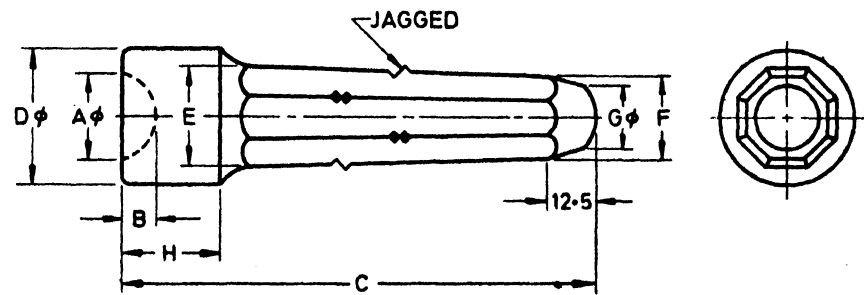


All dimensions in millimetres.

Nominal Size <i>d</i> *	A	B	C	D	E	F	G	H
1.6	2.5	1.0	100	12	10	9	7	12
2	3.2	1.3	100	12	10	9	7	12
2.5	4.0	1.5	100	14	11	10	8	14
3	4.8	1.9	100	15	12	11	9	15
4	6.3	2.5	100	17	14	12	10	17
5	7.9	3.2	115	17	14	12	10	17
6	9.5	3.8	115	21	18	16	12	21
8	12.6	5.0	120	24	20	17	14	24
10	15.8	6.3	120	26	23	20	16	26

**d* = diameter of rivet.

2.3 Snaps, Type C



All dimensions in millimetres.

Nominal Size <i>d</i> *	A	B	C	D	E	F	G	H
12	19.0	7.6	114	32	24	19	14	22
14	22.0	8.8	120	34	25	20	16	25
16	25.3	10.0	125	37	28	22	16	27
18	28.5	11.4	130	41	30	24	18	30
20	31.6	12.6	135	45	33	28	20	34
22	34.3	13.9	145	48	36	29	21	38
24	38.0	15.1	155	54	40	32	24	43
27	42.7	17.0	160	60	45	36	26	49
30	47.4	18.9	170	65	48	39	29	54
33	52.2	20.8	180	71	53	43	32	59
36	56.9	22.7	185	73	55	44	33	62
39	61.6	24.6	190	76	57	46	34	64
42	66.8	26.5	195	81	61	49	37	70
48	75.8	30.0	200	91	68	55	41	77

**d* = diameter of rivet.

2.4 The tolerances on the dimensions shall be in accordance with the best manufacturing practices.

3. Material — The material shall be suitable forging steel meeting with the requirements laid down in 4 and 7.

Example of Suitable Steel:

C65 of IS : 2004-1970 ' Specification for carbon steel forgings for engineering purposes '.

4. Hardness — The tools shall be suitably heat-treated to have a hardness of 500 to 600 HV [see IS : 1501-1968 Method for Vickers hardness test for steel (*first revision*)] [49 to 55 HRC (see IS : 1586-1968 Methods for Rockwell hardness test (B and C scales) for steel (*first revision*)] from the working end up to a distance of 25 mm. Thereafter, the hardness shall gradually decrease to 250 to 350 HV (22 to 25 HRC).

5. Surface Finish — The tools shall be free from cracks, burrs, pits, flaws, seams, rust scales and other defects, and shall have a smooth finish. All un-finished surfaces shall be either lacquered, enameled, painted or have a natural finish with an oil coating.

6. Designation — The snaps and set-ups shall be designated by the commonly used name, type, nominal size and IS number. A snap of Type Band of nominal size 3 mm shall be designated as:

Snap B3, IS : 6836

7. Tests

7.1 Flaw Test — Each snap and set-up, with the working end downwards, shall be placed vertically on an anvil interposing a mild steel plate 10 mm thick. Five blows shall be struck on the striking end with 1 kg hammer. The snap and set-up shall show no sign of damage on completion of the test.

7.2 Performance Test — Sample rivet set shall be tested under practical service conditions by driving and setting at least 10 cold rivets of steel. The rivets shall be of the size specified for that particular size tool and which would normally be headed with the size rivet set under test. The sample rivet set under test shall show no signs of bending, breaking or fracture.

8. Marking — Every snap and set-up shall be legibly marked with the type, nominal size, and the manufacturer's name, initials or recognized trade-mark.

8.1 ISI Certification Marking — Details available with the Indian Standards Institution, New Delhi 1.

9. Sampling — Unless otherwise agreed to between the supplier and the purchaser, the procedure given in IS : 2500 (Part I) - 1963 ' Sampling inspection tables: Part I Inspection by attributes and by count of defects ' shall be followed for sampling inspection. The sampling plan for various characteristics shall be as given in 9.1 and 9.2.

9.1 For dimensions, the sampling plan with inspection level III and acceptable quality level (AQL) 2.5 percent given in Tables 1 and 2 of IS : 2500 (Part I) - 1963 shall be followed.

9.2 For hardness and tests, the sampling plans with inspection level I and acceptable quality level (AQL) 2.5 percent given in Tables 1 and 2 of IS : 2500 (Part I) - 1963 shall be followed.

EXPLANATORY NOTE

This standard lays down the requirements for three types of snaps and set-ups. While preparing this standard assistance has been derived from DIN 6435-1969 Nietkopfmacher (Rivet headers) issued by Deutscher Normenausschuss and the Specification on snaps and set-ups issued by the Chief Inspectorate of General Stores, Kanpur.