AEROSPACE
MATERIAL SPECIFICATIONS
SOCIETY OF AUTOMOTIVE ENGINEERS, Inc. 485 Lexington Ave., New York 17, N.Y.

AMS 7235

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Revised

RIVETS, STEEL, CORROSION AND HEAT RESISTANT
15Cr - 26 Ni - 1.3 Mo - 2.1 Ti - 0.3V
Annealed (1650 F) and Partially Precipitation Heat Treated

1. ACKNOWLEDGMENT: A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.

2. APPLICATION: High quality rivets requiring high strength up to 1200 F and oxidation resistance up to 1500 F. Rivets shall not be hand peened during driving.

3. MATERIAL: Shall be AMS 5734 steel.

4. CONDITION: Cold headed unless purchaser permits machining, annealed unless machined from annealed wire, and partially precipitation heat treated.

5. TECHNICAL REQUIREMENTS:

5.1 Heat Treatment:

5.1.1 Annealing: Cold headed rivets shall be annealed by heating to 1650 F ± 25, holding at heat for 25 min., and quenching in oil.

5.1.2 Precipitation Heat Treatment: All rivets shall be partially precipitation heat treated by heating to a temperature within the range of 1250 - 1350 F, holding at the selected temperature for a time within the range of 30 - 90 min. as necessary to meet shear strength requirements, and cooling in air.

5.2 Shear Strength: The shank shall have shear strength of 80,000 - 95,000 psi as heat treated and not lower than 90,000 psi after being driven.

5.3 Formability: Rivets shall be capable of being driven satisfactorily with a full head free from cracks as determined by metallurgical examination.

6. QUALITY: Parts shall be uniform in quality and condition, clean, sound, smooth, and free from foreign materials and from internal and external imperfections detrimental to their performance.

7. REPORTS: Unless otherwise specified, the vendor of the product shall furnish with each shipment three copies of a report stating that the product conforms to the condition, chemical composition, and technical requirements of this specification. This report shall include the purchase order number, material specification number, part number, nominal size, and quantity.

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