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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 106

LIGHT METAL RIVETS FOR SHIPBUILDING
NOMINAL DIAMETERS, RIVET HOLE DIAMETERS AND CLEARANCES

1st EDITION

May 1959

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BRIEF HISTORY

The ISO Recommendation R 106, *Light Metal Rivets for Shipbuilding - Nominal Diameters, Rivet Hole Diameters and Clearances*, was drawn up by Technical Committee ISO/TC 8, *Shipbuilding Details*, the Secretariat of which is held by the Stichting Nederlands Normalisatie-Instituut (NNI).

The Technical Committee assigned the preliminary study of this question to its Working Group No. 1, *Light Metals and their Alloys used in Shipbuilding*. This Working Group drew up a draft proposal, based on a proposal put forward by the German Member Body for nominal diameters of rivets, rivet holes and clearances. So as to avoid having intervals too far apart, it was decided to propose a series of nominal diameters in millimetres and not in inches.

The draft proposal drawn up by the Working Group was examined by the Technical Committee during its third meeting, held in Genoa, in November 1956, and was unanimously adopted by the delegations present as a Draft ISO Recommendation.

After the meeting, this adoption was confirmed in the course of voting by letter ballot, as no objections were raised.

On 27 December 1957, the Draft ISO Recommendation (No. 184) was distributed to all the ISO Member Bodies and was approved by the following Member Bodies:

Belgium	France	Pakistan
Bulgaria	Germany	Poland
Burma	Italy	Portugal
Canada	Japan	Spain
Czechoslovakia	Netherlands	Turkey
Finland	New Zealand	U.S.S.R.

One Member Body opposed the approval of the Draft: United Kingdom.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in May 1959, to accept it as an ISO RECOMMENDATION.

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DIMENSIONS IN MILLIMETRES

Rivet diameter			Rivet hole diameter		Clearance	
nominal	minimum	maximum	minimum	maximum	minimum	maximum
3	2.9	3.0	3.1	3.2	0.1	0.3
4	3.9	4.0	4.1	4.2	0.1	0.3
5	4.9	5.0	5.1	5.2	0.1	0.3
6	5.9	6.0	6.1	6.2	0.1	0.3
8	7.8	8.0	8.1	8.2	0.1	0.4
10	9.8	10.0	10.1	10.2	0.1	0.4
12	11.8	12.0	12.1	12.2	0.1	0.4
14	13.8	14.0	14.1	14.2	0.1	0.4
16	15.8	16.0	16.1	16.2	0.1	0.4
18	17.8	18.0	18.1	18.2	0.1	0.4
20	19.8	20.0	20.2	20.3	0.2	0.5
22	21.8	22.0	22.2	22.3	0.2	0.5
24	23.8	24.0	24.2	24.3	0.2	0.5

This ISO Recommendation does not anticipate provisions which may be made by Technical Committee ISO/TC 7, *Rivets*, with respect to the general standardization of rivets.