

AERONAUTICAL MATERIAL SPECIFICATIONS

AMS 7234

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Revised

RIVETS, BLIND, ALLOY, CORROSION RESISTANT
67Ni - 30Cu - 0.04S

1. ACKNOWLEDGMENT: A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.
2. APPLICATION: Primarily for two-piece, tubular, blind rivets composed of a preassembled hollow rivet on a pull stem, requiring corrosion resistance at temperatures up to 800 F, for rapid assembly in blind or open locations where high shear strength is required.
3. COMPOSITION:
 - 3.1 Hollow Portion:

Nickel + Cobalt	63.0 - 70.0
Cobalt, if determined	1.0 max
Sulfur	0.025 - 0.060
Iron	2.5 max
Manganese	2.0 max
Silicon	0.50 max
Carbon	0.30 max
Copper	remainder
 - 3.2 Self-Plugging Stem or Mandrel: Shall conform to 3.1 or to AMS 4730.
 - 3.3 Pull-Through Stem or Mandrel: Shall be low carbon steel.
4. CONDITION:
 - 4.1 Hollow Portion: Cold headed, unless purchaser permits machining of the head, pierced or drilled, and annealed, and descaled if necessary. It shall be fabricated from wire cold drawn from hot finished wire or rod which has been previously ground or has had surface preparation (other than by pickling) for removal of seams and other injurious surface imperfections.
 - 4.2 Self-Plugging Stem or Mandrel: Cold headed, unless purchaser permits machining, from cold worked material. It shall be fabricated from material as in 4.1 or from wire cold drawn from hot finished wire or rod.
5. TECHNICAL REQUIREMENTS:
 - 5.1 Shear Strength; Self-Plugging Rivets: Parts shall have shear strength not lower than 52,000 psi when sheared in a conventional type shearing jig.
 - 5.2 Retention of Stem; Self-Plugging Rivets: Stems of installed rivets shall withstand an axial force of 15 lb without being forced out of the rivet.

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