

[INCH-POUND]
 A-A-3043
October 29, 1996
 SUPERSEDING
 GGG-R-00395
 July 27, 1996

COMMERCIAL ITEM DESCRIPTION

RIVETER, BLIND, HAND AND HEADS

The General Services Administration has authorized the use of this Commercial Item Description for procurement of size 1 and 2, style 1, class 2, and style 2, class 2 riveter specified in GGG-R-00395 (GSA-FSS) for all federal agencies.

1. SCOPE.

1.1 Scope. This Commercial Item Description covers a lightweight, hand-operated riveter.

1.2 Intended purpose. The riveter is used with pulling head, installs 1/8-, 5/32-, and 3/16-inch diameter countersunk, self-plugging and hollow pull-through, serrated stem blind rivets.

2. CLASSIFICATION.

2.1 Classification. The riveter covered by this Commercial Item Description shall be of the following sizes and styles:

Riveter

Size 1 - 9-1/2-inch nominal length
 Size 2 - 18-1/2-inch nominal length

Heads

Style 1 - Straight
 Class 2 - Countersunk
 Style 2 - Right angle
 Class 2 - Countersunk

3. SALIENT CHARACTERISTICS.

3.1 Design. The riveter shall be designed for continuous operation and the parts shall not work loose in service or show excessive wear. Riveters and heads shall be of steel construction and shall be suitable for the purpose intended. All threaded parts shall conform to FED-STD-H28. The riveter shall consist essentially of a body and a compound lever assembly, and shall be similar to Figure 1. When specified (see 7.2), pulling heads shall be furnished with each riveter. The pulling heads shall be similar to Figure 2.

Beneficial comments, recommendations, additions, deletions, clarifications, etc., and any other data which may improve this document should be sent to: General Services Administration, Federal Supply Service, Tools and Appliances Commodity Center, Kansas City, MO 64131.

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3.1.1 **Illustrations.** Except for the technical requirements (e.g., design, dimensions), the illustration herein is descriptive and is not intended to preclude the purchase of items otherwise conforming to the requirements of this description.

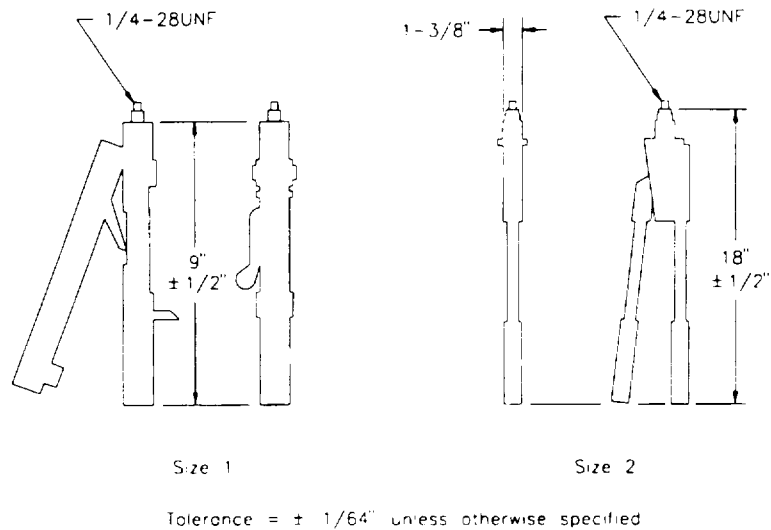


Figure 1. Riveter.

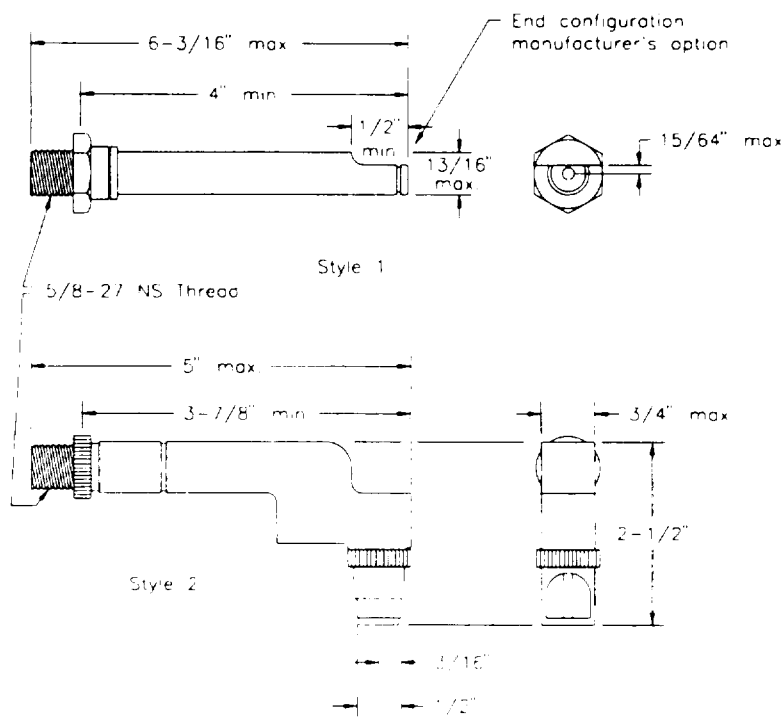


Figure 2. Pulling heads, straight and right angle.

3.1.2 Body and lever assembly.

3.1.2.1 Size 1 riveter assembly. The size 1 riveter body assembly shall be a seamless steel housing, internally threaded 5/8-27 NS at the working end. Within the housing there shall be a removable steel spring and gear rack assembly. The rack shall have a threaded 1/4-28 UNF spindle end and a hardness of 41 to 51 HRC when tested in accordance with ASTM E18. There shall be a removable pawl spring and latch assembly attached to the body to engage the pawl with the rack. The tool shall be suitable for a one-hand operation, and shall be of the dimensions specified in Figure 1.

3.1.2.2 Lever assembly. The size 1 lever assembly shall consist of a handle, removable pawl assembly, and stop cushion. The handle shall be made of C1095 steel or greater and shall have a hardness of 42 to 48 HRC when tested in accordance with ASTM E18. The pawl shall have a hardness of 43 to 53 HRC when tested in accordance with ASTM E18. The lever assembly shall be affixed to the body by a clamp, pivot pin, or other components, and shall be similar to Figure 1.

3.1.2.3 Size 2 riveter assembly. The size 2 riveter body assembly shall be similar to size 1 except the tool shall have long handles and be designed for two-handed operation. The riveter shall be of the dimensions specified in Figure 1.

3.2 Pulling heads. When specified (see 7.2), pulling heads shall be furnished for installing countersunk, self-plugging, and hollow pull-through, serrated stem rivets of 1/8-, 5/32-, or 3/16-inch diameter in accordance with MS20600, MS20601, and MS20604. The heads shall be of the straight or right-angle style, as specified (see 7.2).

3.2.1 Style 1, straight. The style 1, straight pulling head shall be similar to Figure 2. The head shall consist of a side-slotted outer tube, male 4/8-27 NS thread on one end, with a lock nut. Inside the outer tube, there shall be a drawbolt assembly with 1/4-28 UNF thread on the same end as the outer tube thread. The opposite end shall contain a three-jaw serrated chuck and collet.

3.2.1.1 Chuck and collet. The chuck shall be serrated to a depth sufficient enough to engage the rivet stem for proper installation. The hardness of the chuck shall be 51 to 58 HRC when tested in accordance with ASTM E18, or hardened 0.003 to 0.005 inch deep. The inside diameter of the chuck and collet shall be sized to allow for ejection of the rivet stem through the slotted outer tube. The chuck jaws shall not bind on the rivet stem or cause stripping of the rivet pintail. A means shall be provided to assure that the drawbolt ejection passage is aligned with the slotted outer tube to prevent jamming of ejected rivets.

3.3 Style 2, right angle. The style 2, right angle pulling head shall be similar to Figure 2, and shall consist essentially of a steel housing containing a ratchet and spring mechanism with chuck, collet, and drawbolt arrangement for installing blind rivets at right angles to the drawbolt axis. The pulling head shall be male threaded on one end and furnished with a lock nut for attachment to the riveter.

3.3.1 Chuck and collet. The chuck and collet shall be as specified in 3.2.1.1.

3.4 Performance. When assembled, the riveters and pulling heads shall, by compression of the lower lever against the riveter body, install the rivet and break the stem at the predetermined location. The riveter shall quickly return to its loading position.

3.5 Carrying case. When specified (see 7.2), a sturdily constructed metal or plastic case with handle shall be furnished for holding the riveter and heads; or riveter, heads, and accessories for storage and transporting. If metal, the case shall be of corrosion-resisting material or have a painted finish.

3.6 Accessories. When specified (see 7.2), accessories as indicated in 3.6.1 and 3.6.2 shall be furnished with each riveter.

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3.6.1 Plier. The pliers shall be short nose, diagonal cutting style except that the handle shall be offset at a minimum of 15 degrees away from the cutting side of the jaws. The pliers shall have a nominal overall length of 7 inches and shall be capable of trimming close nickel-copper alloy rivet stems.

3.6.2 Selector gauge. The selector gauge shall be of corrosion-resistant, lightweight metal. The gauge shall be marked in increments of 1/16 inch and shall be suitable for measuring countersunk rivet diameters, material thickness, and grip lengths.

3.7 Rivet installation, sizes 1 and 2. The pulling head shall be threaded to the riveter. Using a test plate, the riveter shall install (by continuous rotation) 25 rivets (MS 20600 and MS 20601) for each size pulling head. The riveter and the pulling head shall be disengaged; the handle, pawl, spring, threads, and the pulling head serrated jaws and threads shall show no signs of deformation or damage that will either affect serviceability of either component or prevent the proper installation of the rivet. When the specified item is the riveter only, a pulling head similar to Figure 2, size 3/16 inch, shall be used.

3.8 Finish. All surfaces shall be polished and coated with a rust-preventative oil.

3.9 Identification marking. The riveter shall be marked with the manufacturer's name or identifying symbol and the state or country of manufacture, unless otherwise specified. All identification markings shall be engraved, etched, molded, or indented directly on the item's surface in such a manner that it remains clearly legible throughout the life of the item.

3.10 Workmanship. Details of workmanship shall be in accordance with the best commercial practice. Paints, coatings, platings, and finishes shall be smooth, adherent, continuous, and not stained or discolored. External surfaces shall be free of tool and gouge marks, nicks, or other surface imperfections. The item shall be free from manufacturing workmanship defects (e.g., sharp or rough external edges, corners, or surfaces) and material workmanship defects (e.g., pits, rips, fins, burrs, tears, nodules, cracks, blisters) which may adversely impact the item's serviceability, durability, safety, or appearance.

4. REGULATORY REQUIREMENTS.

4.1 Recovered materials. The offeror/contractor is encouraged to use recovered materials to the maximum extent practicable, in accordance with paragraph 23.403 of the Federal Acquisition Regulation (FAR).

4.2 Metric products. Products manufactured to metric dimensions will be considered on an equal basis with those manufactured using inch-pound units, provided they fall within the tolerances specified (using conversion tables contained in the latest revision of Federal Standard 376) and all other requirements of this document are met. If a product is manufactured to metric dimensions and those dimensions exceed the tolerances specified in the inch-pound units, a request should be made to the contracting officer to determine if the product is acceptable.

5. QUALITY ASSURANCE PROVISIONS.

5.1 Product conformance. The product provided to the Government shall conform to the contractually specified requirements. For product characteristics and requirements which are not contractually specified, the provided product shall conform to the producer's own drawings, standards, specifications, and quality assurance practices for the highest quality product commercially offered by the producer. If the product is not commercially offered by the producer, the best commercial practices shall apply. The Government reserves the right to require proof of such conformances prior to first delivery and thereafter as provided for under the provisions of the contract.

5.2 Responsibility for inspection. Unless otherwise specified, the contractor is responsible for the performance of all inspection requirements and may use any commercial facilities (including the contractor's own facilities) suitable for performance of the inspection requirements, unless disapproved by the Government. The Government reserves the right to perform any inspections deemed necessary to assure the item conforms to the specified requirements.

5.3 Bid sample(s). When a bid sample requirement is specified in the solicitation, the bid sample(s) shall be inspected for all salient characteristics by the Government. A failure of any bid sample to meet the salient characteristics shall be cause for rejection.

5.4 First article sample(s). When a first article requirement is specified in the contract, the first article sample(s) shall be inspected for all salient characteristics. A failure of any first article sample to meet the salient characteristics shall be cause for rejection.

6. PACKAGING.

6.1 Packaging. Requirements of preservation, packing, packaging, and marking of packages shall be as specified in the contract or order.

7. NOTES.

(This section contains information of a general or explanatory nature that is not mandatory.)

7.1 Addresses for obtaining copies of referenced documents:

Federal Specifications and Standards: Federal Supply Service Bureau, Specification Section, Suite 8100, 470 L'Enfant Plaza, SW, Washington, DC 20407.

Federal Acquisition Regulations (FAR): Government Printing Office, Superintendent of Documents, Washington, DC 20402-9371.

ANSI/ASQC Z1.4: American Society for Quality Control, P.O. Box 3005, 611 East Wisconsin Avenue, Milwaukee, WI 43201-4606.

ASTM E18: American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

DoD Standardization Documents: Standardization Document Order Desk, 700 Robbins Avenue, Building 4D, Philadelphia, PA 19111-5094.

7.2 Ordering data. Purchasers should select the preferred options permitted herein and should include the following information in procurement documents:

- (a) Title, number, and date of this Commercial Item Description.
- (b) When applicable, the specific size, style, and class, as specified in the Commercial Item Description.
- (c) When applicable, the appropriate NSN(s).
- (d) If bid samples are required, the number of samples required, and the subjective inspection requirements.
- (e) If first article samples are required and the number of samples required.
- (f) If lot sampling inspection is required and the applicable lot sampling requirements. For example:

Examinations. Each sample tool shall be examined for all salient characteristics. The Inspection Level shall be S-2 with an Acceptable Quality Level of 4.0 expressed in terms of defects per hundred units.

Testing. Each sample tool shall be tested for all salient characteristics. The Inspection Level shall be S-3 with an Acceptable Quality Level of 2.5 percent defective.

- (g) Pulling heads, if required with riveter (see 3.1 and 3.2).
- (h) Designate straight or right angle heads (see 3.2.1 and 3.3) and sizes and classes as required.
- (i) Carrying case, if required (see 3.5).
- (j) Accessories, if required (see 3.6, 3.6.1, and 3.6.2).
- (j) What preservation, packing, packaging, and marking of packages are required.

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7.3 National Stock Numbers (NSNs). The following list of NSNs corresponds to the size, style, and class specified in this CID. This list may not be indicative of all possible NSNs associated with this CID.

NSN

5120-00-357-6065, Size 1, with Style 1, Class 2 Pulling Heads

MILITARY INTERESTS:

PREPARING ACTIVITY:

NONE: DoD has no registered interest
in revisions or notices to this Commercial
Item Description until further notice.

GSA - FSS