

INCH-POUND

MIL-R-7885D
AMENDMENT 2
27 April 1996
SUPERSEDING
AMENDMENT 1
31 MARCH 1994

DETAIL SPECIFICATION

**RIVETS, BLIND, STRUCTURAL, MECHANICALLY LOCKED SPINDLE AND
FRICTION LOCKED SPINDLE, GENERAL SPECIFICATION FOR**

**This amendment forms a part of MIL-R-7885D, dated 18 April 1988, and is approved for use
by all Departments and Agencies of the Department of Defense**

PAGE 1

1 2 Change Type I to read as follows

"Type I - Mechanically locked spindle rivets

Style A - Nominal diameter series

Class 1 - Universal head rivets

Class 2 - 100° Flush head rivets

Class 3 - 100° Flush Shear head rivets

Class 4 - N/A

Style B - Oversize diameter (1/64 inch) series (For repair use only, see 6 1)

Class 1 - Universal head rivets

Class 2 - 100° Flush head rivets

Class 3 - N/A

Class 4 - Flanged Dome head rivets

DD Form 1426 note Change the name and the address of the Preparing Activity to the following

"Naval Air Systems Command (NAVAIR), (AIR-53033G), Washington, DC 20361-5300 "

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PAGE 2

Under Military Specifications, delete the reference to MIL-S-5059 and substitute with

“MIL-T-9046 - Titanium and Titanium alloy, sheet, strip and plate ”

Under Military Specifications, delete the reference to MIL-A-8625

Under Federal Standards, delete the reference to FED-STD-151

Page 3

After 2 2, Remove the reference to AMS 4906

Insert the following before 2 3

American Society for Testing and Materials (ASTM)

B 117 Method of Salt Sprav (Fog) Testing

(Application for copies should be addressed to the American Society for Testing and Materials,
1916 Race Street, Philadelphia, PA 19103-1187)

PAGE 5

3 7 2 After the first comma in the first sentence insert the following words

“always keeping the rivet head pressed against the coupon forming a blind head ”

PAGE 9

4 6 4 Add the following sentence

“Rivets shall be tested at max grip in coupons of 1/2 G thickness where G = Max Grip Spacers may be
installed on the blind side for rivet grips greater than those listed in Table III ”

4 6 4 and 4 6 5 Add the following sentence

“The load rate shall not exceed 110,000 pounds per minute per square inch of fastener cross sectional area
up to the approximate yield load after which it may be increased ”

PAGE 11

Paragraphs 4 6 13 and 4 6 13 1, replace the words Method 811 of FED-STD-151” with “ASTM B 117”

PAGE 14

Paragraph 4 7 9 replace the words Method 811 of FED-STD-151 with ASTM B 117”

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Add the following sentence as 6 2 2

"6 2 2 Acquisition of rivets manufactured prior to issuance of Amendment 1 Unless otherwise specified, Amendment 1 is applicable to rivets manufactured after 31 March 1994 "

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Table III Where Class 1 is specified, change to "Class 1 (Style A and B) and Class 4 (Style B only)"

Table III Where Class 2 is specified, change to "Class 2 (Style A and B) and Class 3 (Style A only)"

PAGE 26

Table XV Hole Dimensions - Type I For 125 diameter (Style B), change hole diameter from " 145 " to " 144 "

Table XIX Change tolerances on listed installation hole diameters from "+ 0000 - 0005" and "+ 0005 - 0000" to ± 0005 "

PAGE 30

Figure 3 change Note 1 to read

1 "Material Alloy Steel, 46 min HRC "

PAGE 32

Type I rivets, change Note 4 to read

Material Alloy steel 46 min HRC, 2024-T3 Aluminum alloy or 7075-T6 Aluminum alloy "

Figure 5 change to read

Delete 2 inch square dimensions from the coupons for both Type I and Type II rivets

Add "T" dimension to indicate total coupon thickness for Type I rivets

Add Note 5 to Type I

"5 Size and configuration of coupon is optional sufficient material is required to support the load "

Add Note 3 to Type II

3 Size and configuration of coupon is optional sufficient material is required to support the load "

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Figure 6 Redraw ends of middle sheets to show they are defined by "Y" dimension

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Figure 10 change to read

Change 75 inch minimum edge distance as dimensioned on drawing to "2D min " with "3/f" beneath it

Change 75 min for the hole spacing as dimensioned on drawing to "3D min " with "3/f" beneath it

Change Note 1 to read

"1/ Material Alloy steel 46 min HRC When testing aluminum rivets, test plates made of 2024-T3 or 7075-T6 may be used "

Add Note 2

"2/ Number of holes and configuration of test plate is optional "

Add Note 3

"3/ D = DIA of rivet "

PAGE 36

Change Note 1 to read

"1 Material 2024-T3 clad aluminum alloy sheet (UNS A92024) in accordance with QQ-A-250/5 for ~~aluminum alloy sleeve rivets~~ or 6A1-4V titanium alloy sheet (UNS R56401) in accordance with MIL-T-9046 for nickel-copper (monel) alloy rivets

NOTE Changes from previous issue Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extent of the changes

Custodians

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Preparing Activity

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