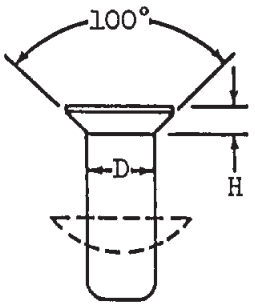
ALLOWABLE ULTIMATE STATIC SINGLE SHEAR STRENGTH FOR NA1097-AD RIVETS - FLUSH HEAD COLD DIMPLED - MACHINE COUNTERSUNK 2024-T3 CLAD SHEET (1)

W/D = 6.0



H/D ~ .238

Sheet (2) Thickness	Strength in Lbs. (3)					
	e/D = 1.5			e/D = 2.0		
	Rivet Diameter					
	1/8	5/32	3/16	1/8	5/32	3/16
.016	165			165		
.020	195	260		195	295	
.024	215	315	375	215	345	425
.028	255	365	440	255	380	500
.032	285	415	500	285	415	570
.036	320	445	560	320	445	640
.040	350	475	625	350	475	675
.045	388	515	700	388	515	705
.050		550	740		550	740
.056		596	775		596	775
.063			820			820
.071			862			862

(1) All test specimens were single shear, single rivet lap joints. Ref. Grumman Report GE-148 and 128MT509.

(2) The thickness of the machine-countersunk lower sheet must be at least one tabulated gauge thicker than the dimpled sheet; and the minimum gauge of the lower sheets are .032, .040 and .050 for the 1/8, 5/32 and 3/16 diameter rivets respectively. Ref. Engineering Manual, Section D.

(3) Yield strength is not critical (1.304 x yield load exceeds design ultimate load for all cases listed).