

NEW ZEALAND GOVERNMENT RAILWAYS MECHANICAL BRANCH	MANUFACTURE OF RIVETS Cancelled 267-82; 7/7/82	CODE No. 53
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EXISTING LOCOMOTIVE CODES TO BE CANCELLED: NIL.

(1) MATERIAL

(a) **Quality.**- The materials to be used for the manufacture of rivets are as follows:-

(1) All Boiler Rivets and Rivets Used on Locomotives and Rolling-stock: —B.S.S. No. 24, Part 6—  
—Specification 16-1942 [BS 24 Part 6 Section 5 Grade 652]

[C.M.E.'s 24/563 of 13.2.61]

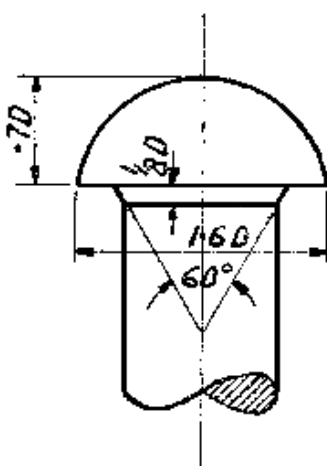
(2) Rivets for Bridges and Construction Work for the Maintenance Branch: B.S.S. No. 15-1936 (N.Z.S.S. 390)

(b) **Marking.**- Bar material for the manufacture of rivets is to be colour marked in accordance with Code No. 72..

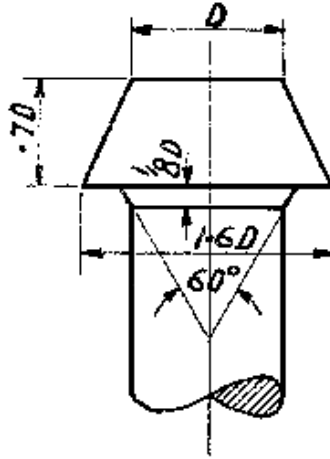
(2) MANUFACTURE

(a) **Dimensions.**- The forms and proportions of rivets heads are to be as shown below:-

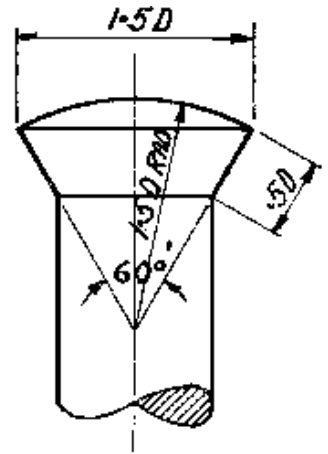
(1) **Boiler Rivets: B.S.S. 425-1943 D = Nominal Diameter of Rivet**



Snap Head

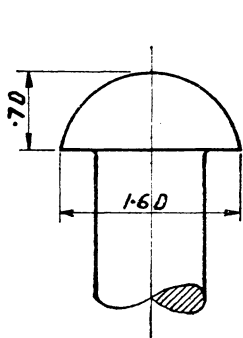


Pan Head

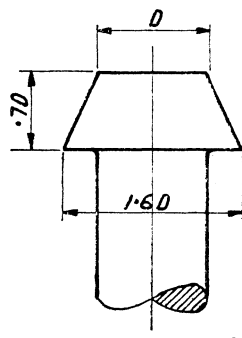


Rounded Countersunk Head

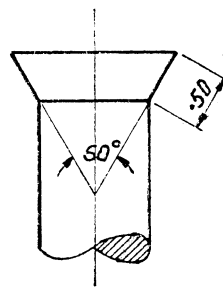
(2) **Rivets Other Than Boiler Rivets: B.S.S. 275 - 1927 (N.Z.S.S. 344)**



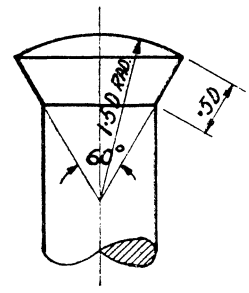
Snap Head



Pan Head



Flat Countersunk Head



Rounded Countersunk Head

(b) **Quantity.**- The manufacture of rivets is not to be put in hand for orders of less than 2 cwt. of the same diameter in the case of rivets under 1/2 in. diameter, or less than 5 cwt. of the same diameter for rivets 1/2 in. diameter and over. If unable to place orders for the minimum weight of one size, District Storekeepers may make up the required weight in smaller quantities of different lengths but the same diameter.

(c) **Storing.**- All rivets manufactured in Workshops are to be received by the Stores Branch and stored in bins suitably branded to indicate the length and diameter of each type of rivet and marked with the colour specified in Code No. 72.

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(d) **Tests for Manufactured Rivets.**- Samples of each batch of rivets manufactured must be subjected to the following tests:-

- (1) The rivet shank is to be bent cold and hammered until the two parts of the shank touch without fracture on the outside of the bend. In the case of rivets with shanks relatively short to the diameter it may not be possible to double over the shank. In such cases a number of rivets must be made with longer shanks to permit the test to be carried out.
- (2) The rivet head is to be flattened while at a red heat until the head is 2.5 times the nominal diameter of the shank, without the appearance of cracks on the edge of the head.
- (3) Rivets are to be gauged at intervals during manufacture to ensure that the variation in diameter of the shanks is within the limits allowed in the British Standard Specifications quoted in subclause 2 (a) above.