

平锥头铆钉 (粗制)

GB 864—86

Cone head rivets—Black

代替 GB 864—76

1 引言

本标准规定了公称直径  $d = 12 \sim 36 \text{ mm}$  的粗制平锥头铆钉。

2 引用标准

GB 116—86 铆钉技术条件。

3 尺寸

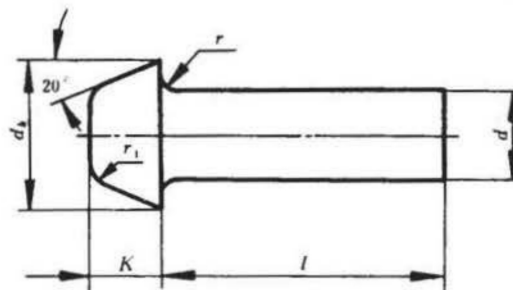


表 1

mm

|       | 公称  | 12   | (14) | 16   | (18) | 20    | (22)  | 24    | (27)  | 30    | 36   |
|-------|-----|------|------|------|------|-------|-------|-------|-------|-------|------|
| $d$   | max | 12.3 | 14.3 | 16.3 | 18.3 | 20.35 | 22.35 | 24.35 | 27.35 | 30.35 | 36.4 |
|       | min | 11.7 | 13.7 | 15.7 | 17.7 | 19.65 | 21.65 | 23.65 | 26.65 | 29.65 | 35.6 |
| $d_k$ | max | 21   | 25   | 29   | 32.4 | 35.4  | 39.9  | 41.4  | 46.4  | 51.4  | 61.8 |
|       | min | 19   | 23   | 27   | 29.6 | 32.6  | 37.1  | 38.6  | 43.6  | 48.6  | 58.2 |
| $K$   | max | 10.5 | 12.8 | 14.8 | 16.8 | 17.8  | 20.2  | 22.7  | 24.7  | 28.2  | 34.6 |
|       | min | 9.5  | 11.2 | 13.2 | 15.2 | 16.2  | 17.8  | 20.3  | 22.3  | 25.8  | 31.4 |
| $r$   | max | 0.5  | 0.5  | 0.5  | 0.5  | 0.8   | 0.8   | 0.8   | 0.8   | 0.8   | 0.8  |
| $r_1$ | max | 2    | 2    | 2    | 2    | 3     | 3     | 3     | 3     | 3     | 3    |

注：尽可能不采用括号内的规格。

表 2

mm

| <i>l</i> |        |        | <i>d</i> |      |    |      |    |      |    |      |    |    |
|----------|--------|--------|----------|------|----|------|----|------|----|------|----|----|
| 公称       | min    | max    | 12       | (14) | 16 | (18) | 20 | (22) | 24 | (27) | 30 | 36 |
| 20       | 19.35  | 20.65  |          |      |    |      |    |      |    |      |    |    |
| 22       | 21.35  | 22.65  |          |      |    |      |    |      |    |      |    |    |
| 24       | 23.35  | 24.65  |          |      |    |      |    |      |    |      |    |    |
| 26       | 25.35  | 26.65  |          |      |    |      |    |      |    |      |    |    |
| 28       | 27.35  | 28.65  |          |      |    |      |    |      |    |      |    |    |
| 30       | 29.35  | 30.65  |          |      |    |      |    |      |    |      |    |    |
| 32       | 31.2   | 32.8   |          |      |    |      |    |      |    |      |    |    |
| 35       | 34.2   | 35.8   |          |      |    |      |    |      |    |      |    |    |
| 38       | 37.2   | 38.8   |          |      |    |      |    |      |    |      |    |    |
| 40       | 39.2   | 40.8   |          |      |    |      |    |      |    |      |    |    |
| 42       | 41.2   | 42.8   |          |      |    |      |    |      |    |      |    |    |
| 45       | 44.2   | 45.8   |          |      |    |      |    |      |    |      |    |    |
| 48       | 47.2   | 48.8   |          |      |    |      |    |      |    |      |    |    |
| 50       | 49.2   | 50.8   |          |      |    |      |    |      |    |      |    |    |
| 52       | 51.05  | 52.95  |          |      | 通  |      |    |      |    |      |    |    |
| 55       | 54.05  | 55.95  |          |      |    |      |    |      |    |      |    |    |
| 58       | 57.05  | 58.95  |          |      |    | 用    |    |      |    |      |    |    |
| 60       | 59.05  | 60.95  |          |      |    |      |    |      |    |      |    |    |
| 65       | 64.05  | 65.95  |          |      |    |      | 规  |      |    |      |    |    |
| 70       | 69.05  | 70.95  |          |      |    |      |    |      |    |      |    |    |
| 75       | 74.05  | 75.95  |          |      |    |      |    |      |    |      |    |    |
| 80       | 79.05  | 80.95  |          |      |    |      |    | 格    |    |      |    |    |
| 85       | 83.9   | 86.1   |          |      |    |      |    |      |    |      |    |    |
| 90       | 88.9   | 91.1   |          |      |    |      |    |      | 范  |      |    |    |
| 95       | 93.9   | 96.1   |          |      |    |      |    |      |    |      |    |    |
| 100      | 98.9   | 101.1  |          |      |    |      |    |      |    | 围    |    |    |
| 110      | 108.9  | 111.1  |          |      |    |      |    |      |    |      |    |    |
| 120      | 118.9  | 121.1  |          |      |    |      |    |      |    |      |    |    |
| 130      | 128.7  | 131.3  |          |      |    |      |    |      |    |      |    |    |
| 140      | 138.7  | 141.3  |          |      |    |      |    |      |    |      |    |    |
| 150      | 148.7  | 151.3  |          |      |    |      |    |      |    |      |    |    |
| 160      | 158.7  | 161.3  |          |      |    |      |    |      |    |      |    |    |
| 170      | 168.7  | 171.3  |          |      |    |      |    |      |    |      |    |    |
| 180      | 178.7  | 181.3  |          |      |    |      |    |      |    |      |    |    |
| 190      | 188.55 | 191.45 |          |      |    |      |    |      |    |      |    |    |
| 200      | 198.55 | 201.45 |          |      |    |      |    |      |    |      |    |    |

注：尽可能不采用括号内的规格。

4 技术条件按GB 116—86规定

5 标记

公称直径 $d = 12\text{mm}$ 、公称长度 $l = 50\text{mm}$ 、材料为ML 2、不经表面处理的平锥头铆钉的标记示例:

铆钉GB 864—86—12×50

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附加说明:

本标准由中华人民共和国机械工业部提出,由机械工业部标准化研究所归口。

本标准由机械工业部标准化研究所负责起草,沈阳标准件工业公司及上海市标准件公司参加起草。