



Standard Test Method for Shear Testing of Aluminum and Aluminum-Alloy Rivets and Cold-Heading Wire and Rods¹

This standard is issued under the fixed designation B 565; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This test method covers the double shear testing of aluminum and aluminum alloy rivets with round, solid shanks and cold-heading wire and rod.²

NOTE 1—Exceptions to this test method may be necessary in individual specifications or methods for tests for a particular material.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parenthesis are mathematical conversions to SI units which are provided for information only and are not considered standard.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 The latest issues of the following documents form a part of this standard to the extent referenced herein:

2.2 *ASTM Standards:*³

B 316/B 316M Specification for Aluminum and Aluminum-Alloy Rivet and Cold-Heading Wire and Rods
B 769 Test Method for Shear Testing of Aluminum Alloys
B 831 Test Method for Shear Testing of Thin Aluminum Alloy Products

E 4 Practices for Force Verification of Testing Machines

E 6 Terminology Relating to Methods of Mechanical Testing

3. Terminology

3.1 *General*—The definitions of terms relating to shear testing in Terminology E 6 are applicable to the terms used in this test method.

4. Summary of Test Method

4.1 The test consists of subjecting a length of wire or rod or a rivet in full cross section, or a machined length of rod or rivet, to double-shear loading, with a suitable test device in a tension testing machine, and determining the shear stress required to fracture the specimen (that is, the shear strength).

5. Significance and Use

5.1 This test method is intended solely for the shear testing of rivets and cold-heading wire and rod, and is not generally recommended for the determination of the shear strength of other products. For rivets, this method is limited to rivets having a shank length equal to or greater than $2d$.

NOTE 2—The results of shear tests of specimens machined from products other than wire, rod, and rivets may be greatly dependent upon the orientation of the specimen within the original test material, and the direction in which the force is applied relative to the grain flow in the specimen.⁴ It is recommended that shear strengths of other products be determined by Test Method B 769 for products greater than 0.250 in. (6.4 mm) and Test Method B 831 for products less than 0.250 in. (6.4 mm). Shear strengths developed by this test method have been shown to vary from those developed by other methods.⁴ If Test Method B 565 is used for shear testing of other products, variables such as those described in Test Method B 769 should be identified and controlled.

5.2 The results of shear tests are dependent upon the relative and absolute lengths of specimen which are sheared out, and those which are supported.⁴ The results of tests made in accordance with this method should not be directly compared with those determined in other types of tests in which the methods of loading and supporting the specimen are different.

¹ This test method is under the jurisdiction of ASTM Committee B07 on Light Metals and Alloys, and is under the jurisdiction of Subcommittee B07.05 on Testing.

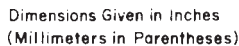
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² This product is covered by Specification B 316/B 316M.

³ For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

⁴ Kaufman, J. G., and Davies, R. E. "Effects of Test Method and Specimen Orientation on Shear Strengths of Aluminum Alloys," *ASTM Proceedings*, ASTEA, Am. Soc. Testing Mats., Vol 64, 1964.

*A Summary of Changes section appears at the end of this standard.



$= \frac{1}{2}$ in. (12 mm) for $d = \frac{3}{16}$ in. (5 mm) to $\frac{3}{8}$ in. (10 mm)

FIG. 1 Shear Test Device

diameter, it is permissible to turn down to 0.372-in. (9.45-mm) diameter for testing. The machined finish shall be 32 μ in. Ra or better.

7.3 The maximum clearance between the specimen diameter and the diameter of the test hole in the device shall not exceed that allowed in Fig. 1.

8. Test Specimen Measurement

8.1 Measure the diameter of the specimen to the nearest 0.001 in. (0.03 mm) for test specimens equal to or greater than 0.1 in. (2.5 mm) in diameter, and to the nearest 0.0005 in. (0.013 mm) for test specimens less than 0.1 in. (2.5 mm) in diameter.

9. Procedure

9.1 The mating surfaces of the shear fixture should be visually inspected before use for aluminum buildup around the test holes. Removal of the aluminum buildup can be accomplished with crocus cloth or soaking the test device in a caustic soda solution followed by a water rinse and drying. Before referee testing, the test device should be cleaned in the above manner followed by procedures in 9.2.

9.2 Since lubrication may have an effect on results (see 5.3), clean the specimens and test device before referee testing (for example, clean ultrasonically in a suitable solvent) and take care to avoid touching the specimen and test-hole area of the shear device with the hands after cleaning.

9.3 Place the specimen in the shear test device, assemble as in Fig. 1, and apply force at a uniform rate until complete failure occurs.

9.4 The cross-head speed during the test shall not exceed $\frac{3}{4}$ in. (19.1 mm)/min and the loading rate shall not exceed 100 ksi (689 MPa)/min on the double-shear test cross section.

9.5 Determine the maximum force to fracture the specimen.

10. Calculations of Shear Strength

10.1 Calculate the shear strength from the maximum force as follows:

$$S = \frac{1}{2}P_{\max}/A = \frac{1}{2}P_{\max}/(\pi D^2/4) = 2P_{\max}/\pi D^2 \quad (1)$$

where:

S = the shear strength, psi (or MPa),
 $P_{\max}$ = the maximum force in the test, lbf (or N), and
 D = the measured diameter of the specimen, in. (or mm).

11. Report

11.1 The report shall include the following for each specimen tested:

11.1.1 The ASTM shear test method.

NOTE 4—In view of the influence of test methods on shear test results as indicated in 5.2, it is important to reference the ASTM test method in reporting results.

11.1.2 Material and sample identification.

11.1.3 Specimen diameter, in. (or mm).

11.1.4 Maximum force, lbf (or N).

11.1.5 Shear strength, ksi (or MPa).

11.1.6 Test temperature, °F (°C).

NOTE 5—For metric equivalents:

1 in = 25.4 mm

1 lbf = 4.448 N

1 ksi = 6.89 MN/m² (MPa)

12. Precision and Bias

12.1 The precision and bias of this test method needs to be established. Subcommittee B07.05 is developing the precision and bias statements for this test method.

13. Keywords

13.1 double shear loading; shear test device; shear aluminum rivet

SUMMARY OF CHANGES

Committee B07 has identified the locations of selected changes to this standard since the last issue (B 565 – 94 (2000)) that may impact its use.

(1) Created 1.2 for the values statement.

(2) Replaced the designation “AA” with “Ra” (Roughness average) in 6.2 and 7.2.

(3) Reordered the procedural steps in Section 9

(4) Added Section 12 on Precision and Bias.

(5) Replaced the word “load” with “force” throughout the standard.

(6) Replaced the words “jig,” “grips,” and “fixture” with “device” throughout the standard.

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