

# ISO 13469:2014-07 (E)

## Mechanical joining - Form-fit blind rivets and (lock) bolt joints - Specifications and qualification of testing procedures

---

<b>Contents</b>		<b>Page</b>
Foreword .....		iv
<b>1</b>	<b>Scope .....</b>	<b>1</b>
<b>2</b>	<b>Normative references .....</b>	<b>1</b>
<b>3</b>	<b>Terms and definitions .....</b>	<b>1</b>
<b>4</b>	<b>Technical contents of the joining procedure specification (JPS) .....</b>	<b>2</b>
4.1	General .....	2
4.2	Related to the fastener manufacturer .....	3
4.3	Related to parent materials .....	3
4.4	Common to all joining processes .....	3
<b>5</b>	<b>Requirements for joints .....</b>	<b>4</b>
5.1	General .....	4
5.2	Test specimen .....	4
5.3	Joining of assembly components, test pieces, or test specimens .....	4
<b>6</b>	<b>Testing and examinations .....</b>	<b>4</b>
6.1	General .....	4
6.2	Visual examination .....	4
6.3	Macro-section/macroscopic examination .....	4
6.4	Tensile shear test .....	6
6.5	Cross tension test .....	8
6.6	Mechanized peel test .....	8
6.7	Fatigue and/or endurance tests .....	8
<b>7</b>	<b>Re-testing .....</b>	<b>10</b>
<b>8</b>	<b>Evaluation of the test results .....</b>	<b>11</b>
<b>9</b>	<b>Single joint specimen test report .....</b>	<b>11</b>
<b>Annex A (informative) Examples of joining procedures for blind rivets and lock bolts .....</b>		<b>12</b>
<b>Annex B (informative) Example of a test report .....</b>		<b>15</b>
<b>Bibliography .....</b>		<b>17</b>