

Specifications for Steel Rivets Rhodesia Railways

Notes to readers

The source documents for this file were held in the National Railways of Zimbabwe Drawing Office in Bulawayo. They were discovered, in March 1998, while I was helping with searching for a complete set of drawings of the 15th Class locomotives after No. 398 had been purchased by a private group in New Zealand for eventual export to that country.

The original documents were duplicated copies, hence the slightly indistinct type in some places. These were photocopied (with permission) on to A4 size paper while in the Drawing Office and the photocopies scanned when we were back in New Zealand.

The scanned files have been lightly “Photoshopped” to remove most of the artefacts resulting from the photocopying and scanning processes and to increase the contrast to make them more readable.

Any alterations, amendments or corrections done by hand have all been left in place and this file is a reasonably accurate reproduction of the original.

Alan Bailey
December 2010

RHODESIA RAILWAYS.

SPECIFICATION FOR STEEL RIVETS.

1.00 Section One - Boiler Quality Rivets.

1.01 Boiler quality rivets are to be manufactured from steel bar conforming to B.S. 24: Part 6: 1957: Section Five: Grade 652. The steel must be "killed". Effervescing steel is not acceptable.

1.02 The form and dimensions of the rivets are to be in accordance with B.S. 425/1943.

1.03 Rivets to this specification are to be made by the hot process; cold made rivets are not acceptable.

1.04 The heads of the rivets are to bear a raised or sunk impression "B".

1.05 See Clause 4.00 for packing.

2.00 Section Two - General Purpose Rivets.

2.01 General purpose rivets are to be manufactured from steel bars conforming to B.S. 24: Part 6: 1957: Section Five: Grade 651. The steel must be "killed". Effervescing steel is not acceptable.

2.02 The form and dimensions of the rivets are to be in accordance with B.S. 641: 1951, for rivets below $\frac{1}{2}$ " diameter and B.S. 275: 1927, for rivets $\frac{1}{2}$ " diameter and above.

2.03 Rivets to this specification are to be made by the hot process; cold made rivets are not acceptable.

2.04 See Clause 4.00 for packing.

3.00 Alternatives.

3.01 Tenderers may offer equivalent alternative material for the manufacture of rivets provided full details of the material in respect of chemical and physical properties are submitted at the time of tendering and that the rivets will withstand the tests of manufactured rivets as laid down in B.S. 24: Part 6: 1957: Section Five.

4.00 Packing.

4.01 The rivets are to be packed by sizes in strong double bags made from new twilled jute sacking, weighing not less than 20 ozs. per square yard. Each bag is to be sewn up separately, the top of the inner bag being placed at the bottom of the outer bag.

4.02 Particulars of the shipping marks, R.R. Order No., Code Number, size and type of rivet are to be shown on two labels of zinc or plywood, one label to be securely wired to each side of the bag.

4.03 Each bag is to contain 100 lbs. of rivets.



A/CHIEF MECHANICAL ENGINEER.

25th July, 1963.

CD/bg