

FED. SUPPLY CLASS

5320

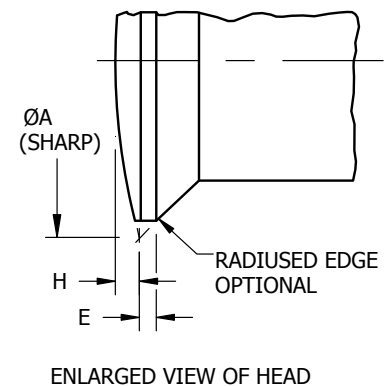
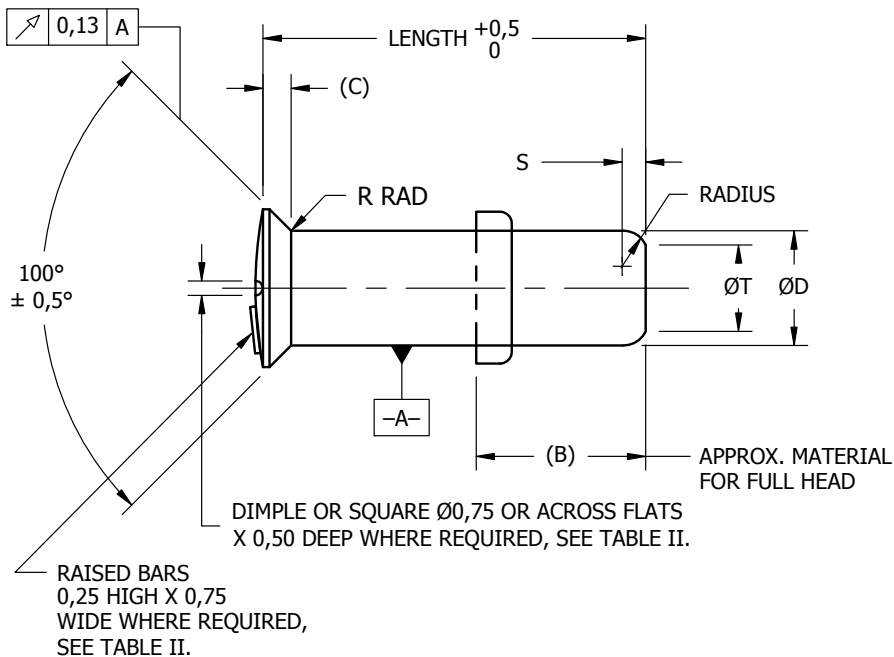


TABLE I – DIMENSIONS

NOMINAL DIAMETER	DIAMETER CODE	ØA (SHARP)	(B)	(C)	ØD	E	H +0,00 -0,05	R RAD	S	ØT
1,6	016	2,50 2,38	2,4	0,41	1,58 1,52	0,15 0,05	0,13	0,23 0,07	0,6 0,3	1,2 1,0
2,5	025	3,90 3,78	3,8	0,63	2,48 2,42	0,17 0,06	0,14	0,23 0,07	0,8 0,5	2,0 1,7
3,0	030	4,68 4,54	4,5	0,74	2,98 2,92	0,18 0,07	0,14	0,23 0,07	0,9 0,6	2,4 2,1
3,5	035	5,46 5,32	5,2	0,87	3,47 3,40	0,20 0,07	0,14	0,33 0,17	1,1 0,7	2,8 2,4
4,0	040	6,24 6,08	6,0	0,99	3,97 3,90	0,21 0,08	0,15	0,33 0,17	1,2 0,8	3,2 2,8
5,0	050	7,80 7,64	7,5	1,23	4,97 4,90	0,23 0,09	0,16	0,33 0,17	1,5 1,0	4,0 3,5
6,0	060	9,36 9,18	9,0	1,46	5,97 5,90	0,25 0,10	0,17	0,33 0,17	1,8 1,2	4,8 4,2
8,0	080	12,48 12,28	12,0	1,95	7,96 7,87	0,30 0,13	0,18	0,33 0,17	2,4 1,6	6,4 5,6
10,0	100	15,60 15,40	15,0	2,42	9,96 9,87	0,35 0,15	0,20	0,33 0,17	3,0 2,0	8,0 7,0

MATERIAL:

ALUMINUM – 1100-H14 (UNS A91100) AND ALUMINUM ALLOYS 2017-T4 (UNS A92017), 2024-T4 (UNS A92024), 2117-T4 (UNS A92117), 2219-T62 (UNS A92219) AND 5056-H32 (UNS A95056) PER QQ-A-430.

① COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NASM5674	TITLE RIVET, SOLID, COUNTERSUNK, 100° SHEAR HEAD, ALUMINUM AND ALUMINUM ALLOY, METRIC	CLASSIFICATION PART STANDARD NA0019 THRU NA0021 SHEET 1 OF 3

HEAT TREATMENT:

2017-T4, 2117-T4, 2024-T4 AND 2219-T62 PER AMS2770.

FINISH:

ANODIZE PER MIL-A-8625, TYPE II, CLASS 1, EXCEPT USE HOT DEIONIZED WATER AT 96 TO 100 °C FOR A CLEAR (COLORLESS) APPEARANCE, OR CHEMICAL FILM FINISH PER MIL-DTL-5541, CLASS 3, CLEAR (COLORLESS), AS CODED.

CODE:

THE BASIC PART NUMBER INDICATES THE MATERIAL (SEE THE TABULATION IN TABLE II).

THE DASH NUMBER CONSISTS OF SIX DIGITS.

THE FIRST THREE DIGITS INDICATE THE SHANK DIAMETER (SEE THE DIAMETER CODE IN TABLE I).

THE SECOND THREE DIGITS DESIGNATE THE RIVET LENGTH IN MILLIMETERS (SEE TABLE III FOR PREFERRED LENGTHS). LENGTHS NOT SHOWN MAY BE SPECIFIED IN 1,0 mm INCREMENTS.

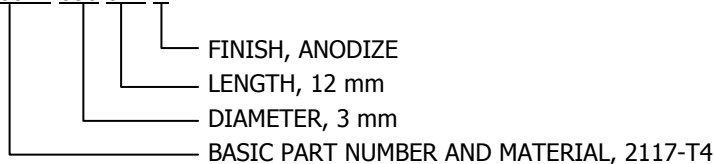
THE LETTER AFTER THE DASH NUMBER IS THE FINISH CODE LETTER.

"N" INDICATES AN ANODIZED AND SEALED FINISH.

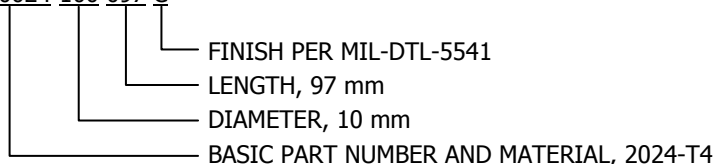
"C" INDICATES A MIL-DTL-5541 FINISH.

EXAMPLES OF PART NUMBERS:

NA0021-030 012 N



NA0024-100 097 C



NOTES:

- (1) TOLERANCE UNLESS OTHERWISE SPECIFIED: DECIMALS $\pm 0,25$.
- (2) A SHANK DIAMETER INCREASE SHALL NOT EXCEED " $\varnothing D$ " MAX + 0,03 WITHIN "X" LENGTH, WHERE "X" = 1,3 + "R" + "(C)", "R" = THE SHANK TO HEAD RADIUS AND "(C)" IS THE HEAD HEIGHT. "X" LENGTH IS MEASURED FROM THE TOP OF THE HEAD TO A POINT ON THE SHANK.
- (3) HEAD COCKING RELATIVE TO AXIS OF RIVET 0,5° MAX.
- (4) SHANK ENDS SHALL HAVE A RADIUS OR A CHAMFER CONSISTENT WITH DIMENSIONS "S" AND " $\varnothing T$ ".
- (5) MAXIMUM RIVET LENGTH 99,0 mm.

① COMPLETELY REVISED

REVISION
1
NA0019 THRU NA0024
SHEET 2



Documents

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