

FED. SUPPLY CLASS

5320

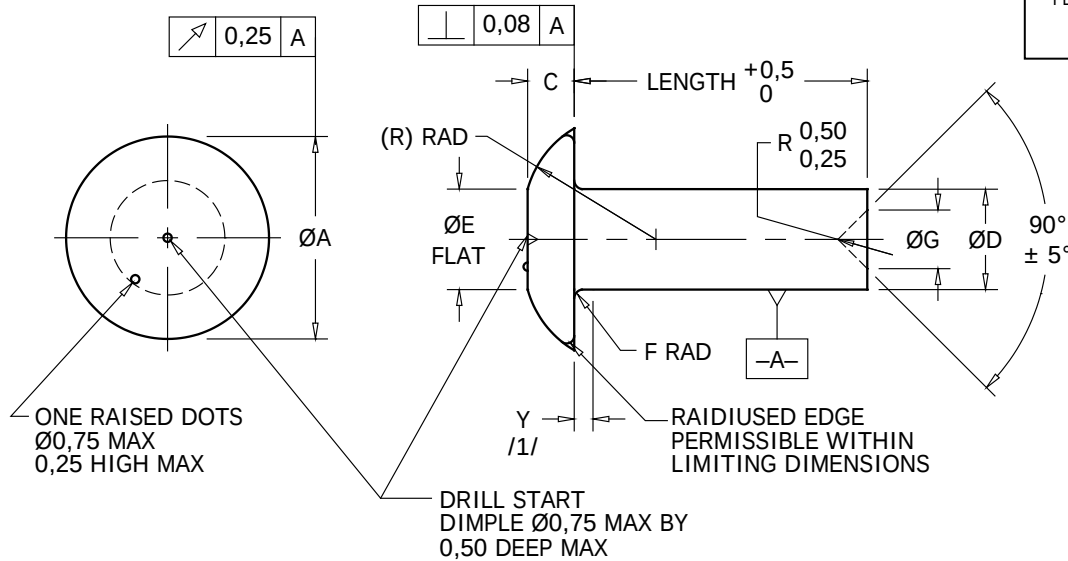


TABLE I – DIMENSIONS

NOMINAL DIAMETER	DIAMETER CODE	$\varnothing A$	C	$\varnothing D$	$\varnothing E$	$\varnothing G$	(R) RAD	F RAD	Y
1,6	016	3,36 3,04	0,89 0,69	1,58 1,52	1,5 1,2	NO RECESS	2,0	0,23 0,07	1,53
2,5	025	5,25 4,75	1,28 1,08	2,48 2,42	2,1 1,8	NO RECESS	3,1	0,23 0,07	1,53
3,0	030	6,30 5,70	1,49 1,29	2,98 2,92	2,5 2,2	1,63 1,37	3,7	0,23 0,07	1,53
3,5	035	7,35 6,65	1,70 1,50	3,47 3,40	2,9 2,6	1,75 1,50	4,3	0,33 0,17	1,63
4,0	040	8,40 7,60	1,92 1,72	3,97 3,90	3,3 3,0	2,13 1,87	4,9	0,33 0,17	1,63
5,0	050	10,50 9,50	2,35 2,15	4,97 4,90	4,0 3,7	2,50 2,25	6,1	0,33 0,17	1,63
6,0	060	12,60 11,40	2,78 2,58	5,97 5,90	4,8 4,5	3,13 2,87	7,4	0,33 0,17	1,63

MATERIAL:

CRES – A286 (UNS S66286) PER AMS5734 OR AMS5737.

HEAT TREATMENT:

HEAT TREATMENT TO BE PERFORMED AFTER HEADING.
HEAT AT 886°C TO 914°C FOR 25 MINUTES, OIL QUENCH.
AGE AT 680°C TO 730°C FOR 30 MINUTES AS NECESSARY TO MEET THE SHEAR REQUIREMENTS, AIR COOL.

FINISH:

PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.

(2) COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NONE	TITLE RIVET, SOLID, UNIVERSAL HEAD, A286 CRES, METRIC	CLASSIFICATION PART STANDARD
		DI00051 SHEET 1 OF 2

CODE:

PART NUMBER CODING CONFORMS TO NAS10000.
INTERMEDIATE RIVET LENGTHS NOT SHOWN IN TABLE II MAY BE SPECIFIED IN 1 mm INCREMENTS
PROVIDED THEY FALL WITHIN THE RANGE OF LENGTHS SHOWN.

EXAMPLE OF PART NUMBER:

NA0051-016 010

LENGTH = 10 mm
DIAMETER = 1,6 mm
UNIVERSAL HEAD A286 RIVET

NOTES:

- /1/ A 0,03 INCREASE IN MAXIMUM SHANK DIAMETER IS PERMISSIBLE WITHIN THE LENGTH "Y".
- (2) RIVETS SHALL UPSET SATISFACTORILY WHEN DRIVEN COLD, FORMING UPSET HEADS THAT ARE FREE FROM CRACKS. SUGGESTED BACK-SIDE SHANK LENGTH PROTRUSION = 1,25 TO 1,3 TIMES THE NOMINAL SHANK DIAMETER.
- (3) RIVETS SHALL BE OF UNIFORM QUALITY AND FREE FROM SCALE, FINS, SEAMS, CLINCH OR DIE MARKS, COLD SHUTS OR OTHER INJURIOUS DEFECTS.
- (4) DIMENSIONS IN MILLIMETERS AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (5) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (6) SHEAR STRENGTH AT ROOM TEMPERATURE: 586 MPA TO 655 MPA AS HEAT TREATED; 622 MPA MINIMUM AFTER DRIVING.
- (7) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (8) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (9) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.

TABLE II – LENGTH DASH NUMBERS

BASIC PART NO.	NOM DIA	LENGTHS AND LENGTH CODE NUMBERS																			
		3,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	22,0	24,0	26,0	28,0	30,0	32,0	36,0	42,0	50,0	
NA0051-016	1,6	003	005	006	008	010	012	014	—	—	—	—	—	—	—	—	—	—	—	—	
NA0051-025	2,5	—	005	006	008	010	012	014	016	018	020	—	—	—	—	—	—	—	—	—	
NA0051-030	3,0	—	005	006	008	010	012	014	016	018	020	022	024	026	028	030	—	—	—	—	
NA0051-035	3,5	—	—	—	008	010	012	014	016	018	020	022	024	026	028	030	032	—	—	—	
NA0051-040	4,0	—	—	—	008	010	012	014	016	018	020	022	024	026	028	030	032	036	042	050	
NA0051-050	5,0	—	—	—	—	010	012	014	016	018	020	022	024	026	028	030	032	036	042	050	
NA0051-060	6,0	—	—	—	—	010	012	014	016	018	020	022	024	026	028	030	032	036	042	050	

REVISION

2

2 COMPLETELY REVISED



Documents
SHEET 2

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