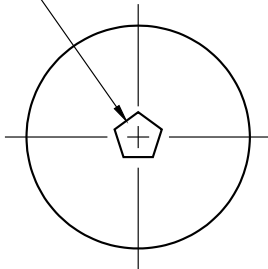


FED. SUPPLY CLASS

5320

HEAD MARKING: PENTAGON,
MAX DEPTH .015 (MFR'S
TRADEMARK MAY BE INCLUDED)



NATURAL FLOW
OF MATERIAL PERMISSIBLE

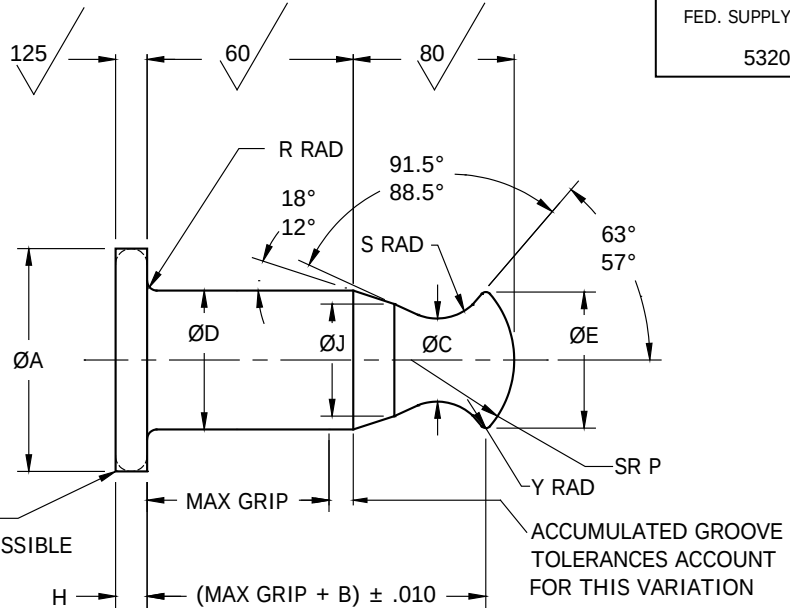


TABLE I – DIMENSIONS

FIRST DASH NO.	NOM DIA OR SIZE	ØA	B	ØC	ØD	ØE	ØJ	H	P	R RAD	S RAD	Y RAD MAX
4	1/8	.208 .188	.083	.079 .075	.1240 .1215	.120 .116	.117 .113	.039 .029	.086 .078	.020 .010	.023 .019	.0075
5	5/32	.262 .242	.114	.098 .094	.1560 .1535	.153 .149	.148 .144	.047 .037	.110 .100	.025 .012	.028 .023	.0075
6	3/16	.315 .295	.125	.119 .115	.1895 .1870	.185 .181	.179 .174	.055 .045	.128 .118	.020 .005	.034 .030	.0075
8	1/4	.412 .387	.165	.156 .152	.2495 .2470	.244 .239	.235 .230	.069 .059	.167 .155	.025 .005	.044 .040	.0075
10	5/16	.505 .475	.206	.194 .189	.3120 .3095	.307 .302	.296 .290	.078 .068	.206 .194	.030 .005	.054 .050	.0075
12	3/8	.600 .565	.248	.232 .227	.3745 .3720	.370 .365	.361 .355	.088 .078	.250 .237	.030 .005	.066 .062	.0075

MATERIAL:

STEEL; CHROME-NICKEL-MOLYBDENUM; BAR AND ROD
 – 8735 (UNS G87350) PER ~~MIL-S-6098~~ AMS6320.
 – 8740 (UNS G87400) PER ~~MIL-S-6049~~ AMS6322, AMS6325 OR AMS6327.
 – 4340 (UNS G43406) PER ~~MIL-S-5000~~ AMS6415 OR AMS6484.
 STEEL; CHROME-VANADIUM; BAR AND BILLET
 – 6150 (UNS G61500) PER ~~MIL-S-8503~~ AMS6448.
 OPTION: STEEL – 3135 (UNS K22033) PER AMS6330.
 STEEL; CHROME-MOLYBDENUM; BAR AND ROD
 – 4140 (UNS G41400) PER ~~MIL-S-5626~~ AMS6349 OR AMS6382.
 – 4130 (UNS G41300) PER ~~MIL-S-6758~~ AMS-S-6758.
 STEEL; MOLYBDENUM; BAR AND ROD – ~~4037~~ PER AMS6300.
 STEEL; BARS AND FORGINGS .25Mo (.35-.40C) – 4037 (UNS G40370) PER AMS6300.

⑤ COMPLETELY REVISED

THIRD ANGLE PROJECTION	
PROCUREMENT SPECIFICATION	
NAS498	

CUSTODIAN	
NATIONAL AEROSPACE STANDARDS COMMITTEE	
TITLE	
RIVET, PROTRUDING HEAD ⑤	

REVISION	
5	
CLASSIFICATION PART STANDARD	
NAS1054	
SHEET 1 OF 3	

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE.

FORM 09-01

REVISION DATE: JANUARY 31, 2013
ISSUE DATE: DECEMBER 1956

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-6875 OR AMS2759: 160 TO 180 KSI Ft_u.

FINISH:

CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. PLATING THICKNESS .0002 TO .0005. PARTS WITH CLASS 3 PLATING MAY BE FURNISHED FROM SUPPLIER'S STOCK UNTIL DECEMBER 30, 1974.

CODE:

FIRST DASH NUMBER INDICATES NOMINAL DIAMETER IN THIRTY-SECONDS.
SECOND DASH NUMBER INDICATES MAXIMUM GRIP IN SIXTEENTHS.

EXAMPLE OF PART NUMBER:

NAS1054-8-8 = PROTRUDING HEAD RIVET, CLOSE TOLERANCE HEAD AND SHANK, Ø1/4 (Ø8/32) WITH 1/2 (8/16) MAXIMUM GRIP.

NOTES:

- (1) ENTRANCE CHAMFER SHALL NOT FALL WITHIN THE MAXIMUM GRIP.
- (2) NAS1054 "-4" THRU "-12" RIVETS MAY BE INSTALLED WITH NAS179 OR NAS528 COLLARS OF THE SAME DASH NUMBER.
- (3) MAGNETIC PARTICLE INSPECTION SHALL BE PERFORMED PER ASTM E 1444, USING THE LONGITUDINAL METHOD ONLY, UNDER A SAMPLING PLAN HAVING AN AQL OF 0.035 AND ADMINISTERED AT INSPECTION LEVEL III OF ASQ Z1.4. RIVET HEADS NEED NOT BE DYED.
- (4) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (5) HEAD AND SHANK TO BE CONCENTRIC WITHIN .010 FIM.
- (6) "ØC", "ØE" AND "ØJ" SHALL BE CONCENTRIC WITH "ØD" WITH .005 TOTAL RUNOUT FOR "-4" THRU "-12" SIZES.
- (7) REMOVE ALL BURRS AND SHARP EDGES.
- (8) TOLERANCES AS SHOWN.
- (9) SUPERSEDES NAS178.
- (10) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (11) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (12) REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.
- (13) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (14) SURFACE ROUGHNESS SHALL BE IN ACCORDANCE WITH ASME B46.1 AND SURFACE ROUGHNESS SYMBOLS SHALL BE IN ACCORDANCE WITH ASME Y14.36M.

⑤ COMPLETELY REVISED

REVISION
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