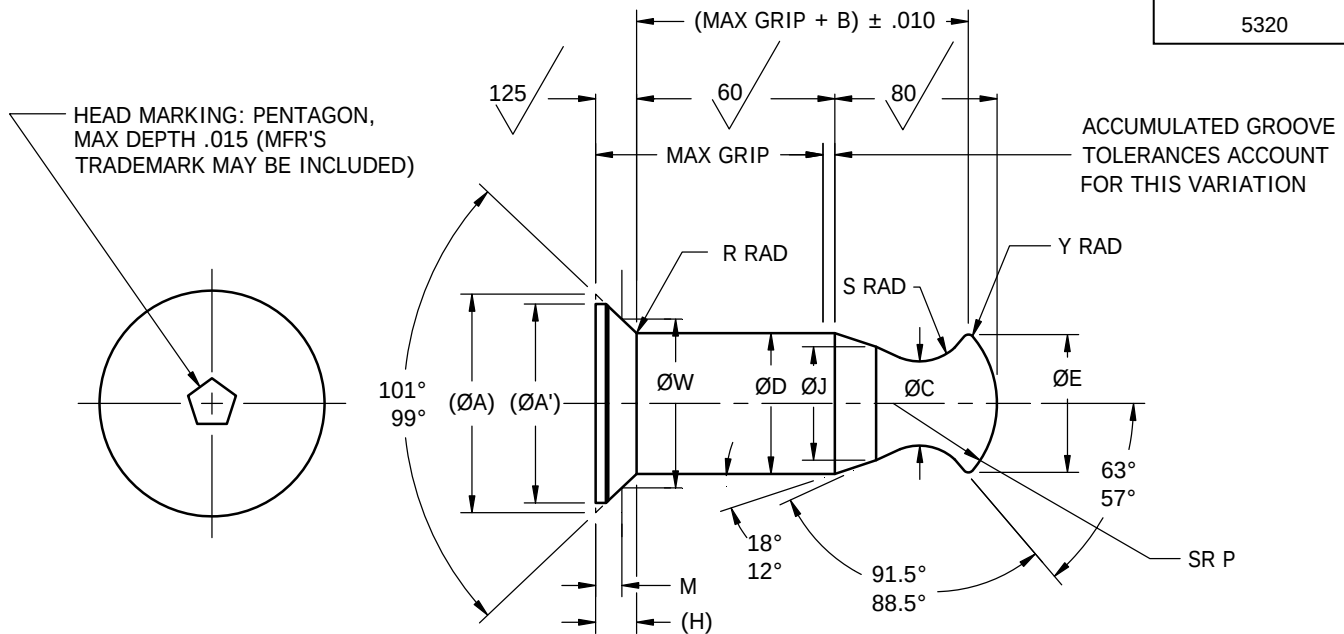


FED. SUPPLY CLASS

5320



6 TABLE I – DIMENSIONS

FIRST DASH NO.	NOM DIA	(ØA) MAX	(ØA') MIN	B	ØC	ØD	ØE	(H) MAX	ØJ	M	P	R	S	ØW +.0002 - .0000	Y MAX	Z MAX
4	.125	.2100	.1787	.083	.079 .075	.1240 .1215	.120 .116	.0354	.117 .113	.0197 .0166	.086 .078	.005 .020	.023 .019	.1626	.0075	.010
5	.156	.2575	.2203	.114	.098 .094	.1560 .1535	.153 .149	.0418	.148 .144	.0220 .0186	.110 .100	.005 .025	.028 .023	.2026	.0075	.012
6	.188	.3047	.2578	.125	.119 .115	.1895 .1870	.185 .181	.0485	.179 .174	.0250 .0210	.128 .118	.005 .030	.034 .030	.2439	.0075	.015
8	.250	.3988	.3504	.165	.156 .152	.2495 .2470	.244 .239	.0631	.235 .230	.0278 .0232	.167 .155	.005 .030	.044 .040	.3313	.0075	.015
10	.313	.4787	.4289	.206	.194 .189	.3120 .3095	.307 .302	.0704	.296 .290	.0305 .0255	.206 .194	.005 .040	.054 .050	.4045	.0075	.015
12	.375	.5662	.5149	.248	.232 .227	.3745 .3720	.370 .365	.0810	.361 .355	.0333 .0277	.250 .237	.005 .040	.066 .062	.4852	.0075	.015

MATERIAL:

STEEL; CHROME-NICKEL-MOLYBDENUM; BAR AND ROD

- 8735 (UNS G87350) PER MIL-S-6098 AMS6320.
- 8740 (UNS G87400) 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 (UNS G40370) PER AMS6300.

STEEL; BARS AND FORGINGS .25Mo (.35-.40C) – 4037 (UNS G40370) PER AMS6300.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 6
PROCUREMENT SPECIFICATION NAS498	TITLE RIVET, 100° FLUSH CLOSE TOLERANCE HEAD	CLASSIFICATION PART STANDARD
		NAS1055 SHEET 1 OF 4

HEAT TREAT:

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

⑥ NAS1055-8-8 = 100° COUNTERSUNK HEAD RIVET, CLOSE TOLERANCE HEAD AND SHANK, Ø.250
WITH .500 MAXIMUM GRIP.

NOTES:

- (1) "M" PROTRUSION VALUES TO BE CHECKED WITH NAS9800.
- (2) HEAD ANGLE, HEAD COCKING, CONCENTRICITY AND THE HEAD TO SHANK FILLET RADIUS TO BE CHECKED WITH AN OPTICAL COMPARATOR OR BY EQUIVALENT METHODS.
- (3) DIMENSION "(ØA)", "(ØA')", AND "(H)" ARE INCLUDED FOR REFERENCE PURPOSES ONLY AND ARE NOT TO BE USED FOR ACCEPTANCE PURPOSES. THESE VALUES ARE CALCULATED LIMITS RESULTING FROM "ØW", "M", "Z" AND HEAD ANGLE WITH APPLICABLE TOLERANCES.
- (4) ENTRANCE CHAMFER SHALL NOT FALL WITHIN THE MAXIMUM GRIP.
- (5) NAS1055 "-4" THRU "-12" RIVETS MAY BE INSTALLED WITH NAS179 OR NAS528 COLLARS OF THE SAME DASH NUMBER.
- (6) SEE NAS9800 FOR THE RECOMMENDED PRACTICE FOR INSPECTION.
- (7) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (8) CONICAL SURFACE OF HEAD AND SHANK TO BE CONCENTRIC WITHIN .005 TOTAL RUNOUT.
- (9) "ØC", "ØE" AND "ØJ" SHALL BE CONCENTRIC WITH "ØD" WITH .005 TOTAL RUNOUT FOR "-4" THRU "-12" SIZES.
- (10) THE TOP SURFACE OF THE HEAD SHALL BE PERPENDICULAR TO THE AXIS OF THE SHANK WITHIN THE LIMITS OF 89° 45' AND 90° 15'.
- (11) REMOVE ALL BURRS AND SHARP EDGES.
- (12) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

REVISION

6

NAS1055
SHEET 2



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