

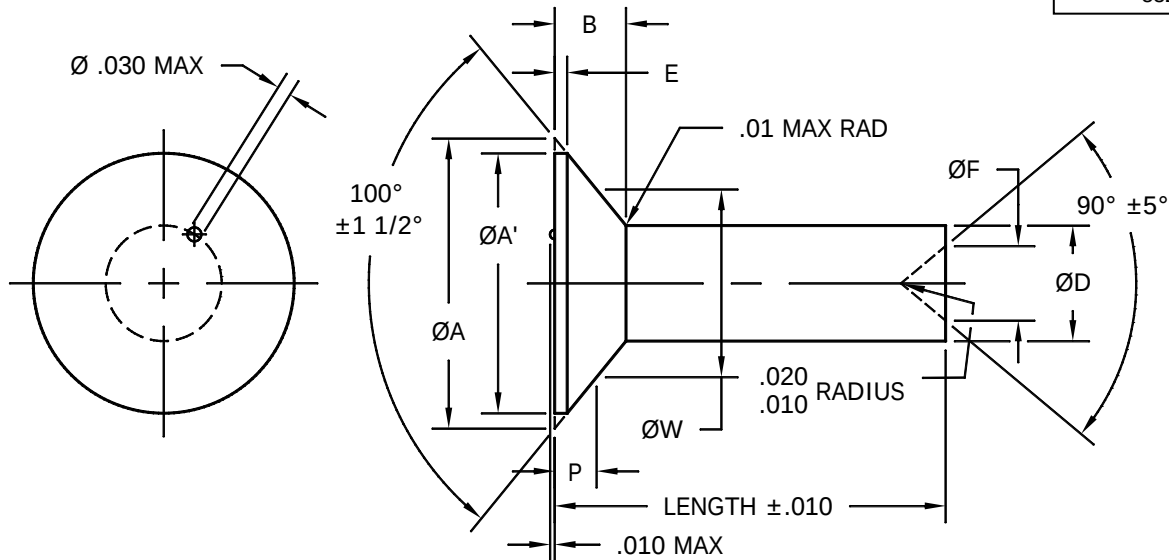


TABLE I – DIMENSIONS

$\varnothing D$	$\varnothing A$ MAX	$\varnothing A'$ MIN	B MAX	E MAX	$\varnothing F$ $\pm .005$	P		$\varnothing W$	
						MAX	MIN	MAX	MIN
.062 $+ .003$ $- .001$	.1346	.0898	.0317	.008	NO RECESS	.0165	.0105	.0842	.0840
.094 $+ .003$ $- .001$	.1900	.1548	.0418	.008	NO RECESS	.0179	.0118	.1462	.1460
.125 $+ .003$ $- .001$	.2360	.2006	.0483	.008	.070	.0191	.0130	.1892	.1890
.156 $+ .004$ $- .001$	.2976	.2566	.0614	.010	.080	.0226	.0163	.2422	.2420
.187 $+ .004$ $- .001$	.3654	.3234	.0769	.010	.100	.0252	.0185	.3038	.3036
.250 $+ .004$ $- .001$	.4890	.4412	.1034	.012	.125	.0289	.0220	.4182	.4180

MATERIAL: A286 CRES (UNS S66286) HI-TEMPERATURE ALLOY HEADING STOCK PER AMS5737.

SHEAR STRENGTH AT ROOM TEMP: 85,000 PSI TO 95,000 AS HEAT-TREATED.
90,000 PSI MINIMUM AFTER DRIVING.

HEAT TREAT: SOLUTION TREAT AND PARTIALLY PRECIPITATION HEAT TREAT AFTER HEADING AS FOLLOWS:
HEAT AT $1650^\circ\text{F} \pm 25^\circ$ FOR 25 MINUTES - OIL QUENCH.
AGE AT 1250°F TO 1350°F FOR 30 TO 90 MINUTES AS NECESSARY TO MEET SHEAR REQUIREMENTS.
AIR COOL.

THIRD ANGLE PROJECTION		CUSTODIAN		REVISION	
		NATIONAL AEROSPACE STANDARDS COMMITTEE		6	
PROCUREMENT SPECIFICATION	NONE	TITLE		CLASSIFICATION PART STANDARD	
		RIVET, SOLID, 100° FLUSH HEAD, A286 CORROSION RESISTANT STEEL		NAS1199 SHEET 1 OF 2	



FINISH: A286 - PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

EXAMPLE OF PART NUMBER: NAS1199-4-8-5

SEE NOTE /9/
LENGTH .500
DIAMETER .125
BASIC NUMBER

- NOTES:
- (1) DIMENSIONS IN INCHES, TOLERANCES UNLESS OTHERWISE SPECIFIED: $\pm .010$.
 - (2) .001 SHANK DIAMETER INCREASE PERMISSIBLE WITHIN .10 OF BASE OF HEAD.
 - (3) SHANK AND HEAD DIAMETERS SHALL BE CONCENTRIC WITHIN .010 FOR RIVETS THRU .125, WITHIN .015 FOR .156 AND .187 RIVETS, AND WITHIN .020 FOR .250 RIVETS, FIM.
 - (4) RIVETS SHALL DRIVE COLD SATISFACTORILY WITH FULL HEADS FREE FROM CRACKS. SUGGESTED SHANK LENGTH PROTRUSION 1-1/4 TO 1-1/3 TIMES RIVET DIA.
 - (5) RIVETS MUST BE OF UNIFORM QUALITY AND FREE FROM SCALE, FINS, SEAMS, CLINCH OR DIE MARKS, COLD SHUTS, OR OTHER INJURIOUS DEFECTS.
 - (6) HEAD COCKING ANGLE RELATIVE TO AXIS OF RIVET .5 DEG MAX.
 - (7) MAXIMUM HEAD DIAMETERS ARE TO THEORETICAL SHARP CORNERS AS MEASURED BY PROJECTION.
 - (8) SEE NAS9800 FOR THE RECOMMENDED PRACTICE FOR INSPECTING HEAD CHARACTERISTICS.
 - /9/ ADDITIONAL .0313 INCREMENTS MAY BE OBTAINED BY ADDING -5 AFTER THE LAST DIGIT OF PART NUMBER.
 - (10) THE HEAD PERIPHERY MAY BE ROUNDED WITHIN THE "E" DIMENSION.
 - (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) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
 - (13) REMOVE ALL BURRS AND SHARP EDGES.
 - ⑥ (14) 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.
 - (15) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

⑥ TABLE II – LENGTHS AND DASH NUMBERS

BASIC PART NUMBER	ØD	.125	.188	.250	.312	.375	.438	.500	.563	.625	.688	.750	.813	.875	.938	1.000	1.125	1.250	1.375	1.500	1.750	2.000
NAS1199-2	.062	-2	-3	-4	-5	-6	-7	-8	-9													
NAS1199-3	.094		-3	-4	-5	-6	-7	-8	-9	-10	-11	-12										
NAS1199-4	.125		-3	-4	-5	-6	-7	-8	-9	-10	-11	-12	-13	-14	-15	-16	-18	-20				
NAS1199-5	.156			-4	-5	-6	-7	-8	-9	-10	-11	-12	-13	-14	-15	-16	-18	-20	-22	-24	-28	-32
NAS1199-6	.187				-5	-6	-7	-8	-9	-10	-11	-12	-13	-14	-15	-16	-18	-20	-22	-24	-28	-32
NAS1199-8	.250				-5	-6	-7	-8	-9	-10	-11	-12	-13	-14	-15	-16	-18	-20	-22	-24	-28	-32

REVISION

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NAS1199
SHEET 2



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