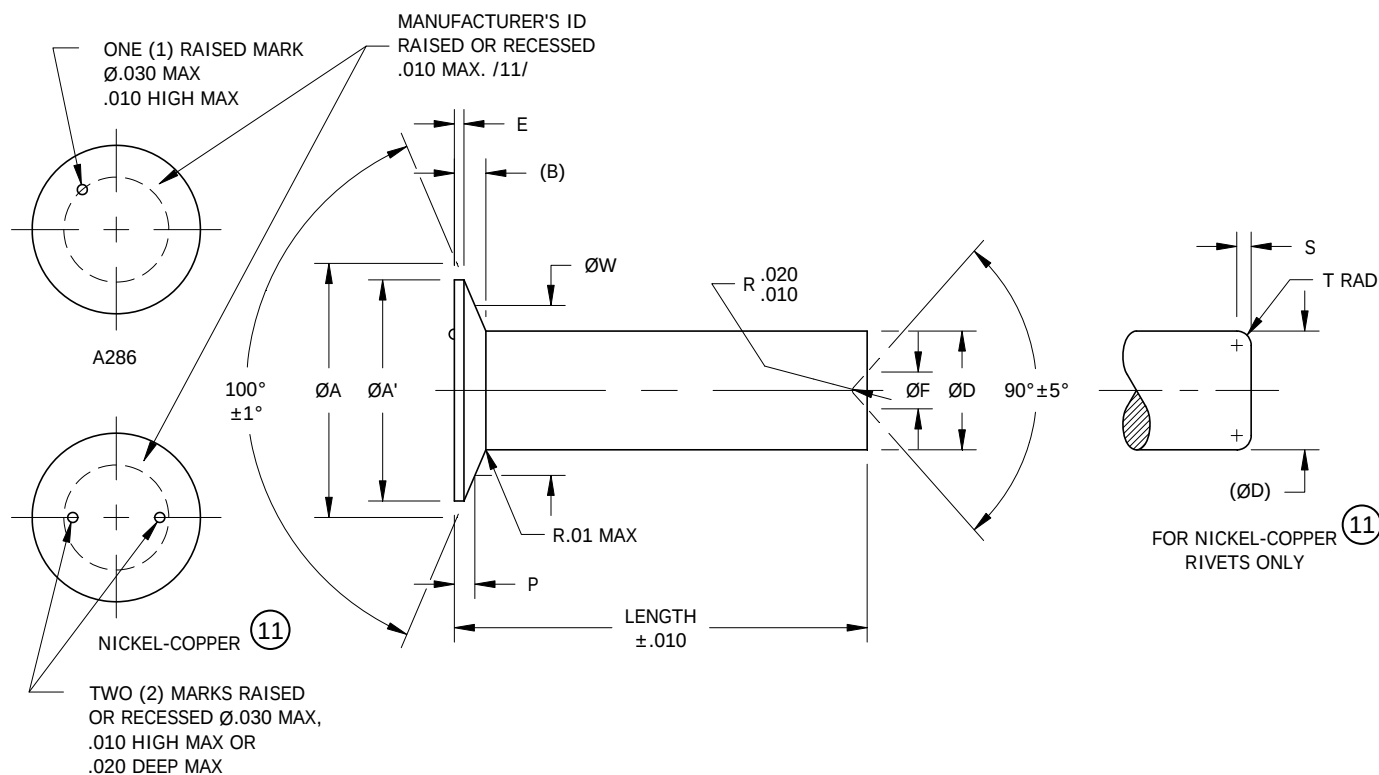


FED.SUPPLY CLASS

5320



⑪ TABLE I – DIMENSIONS

ØD	ØA	ØA' ABSOLUTE MIN	(B)	E MAX	ØF ±.005	P		ØW		S	T RAD
						MAX	MIN	MAX	MIN		
.094 +.002 -.001	.1490 .1398	.1260	.021	.006	NO RECESS	.0123	.0089	.1192	.1190	.023	.029
.125 +.003 -.001	.1970 .1874	.1739	.029	.006	.070	.0141	.0106	.1628	.1626	.031	.039
.156 +.004 -.001	.2487 .2384	.2251	.037	.006	.080	.0189	.0153	.2028	.2026	.039	.049
.187 +.004 -.001	.2987 .2879	.2749	.046	.006	.100	.0225	.0188	.2441	.2439	.047	.059
.250 +.004 -.001	.3953 .3835	.3710	.060	.008	.125	.0263	.0223	.3315	.3313	.062	.078

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1000 WILSON BLVD.
ARLINGTON, VA 22209

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SSUE DATE: MARCH 1959

THIRD
ANGLE
PROJECTION

CUSTODIAN

REVISION

NATIONAL AEROSPACE STANDARDS COMMITTEE

11

PROCUREMENT SPECIFICATION

TITLE

CLASSIFICATION
PART STANDARD

NONE

**RIVET, SOLID, 100° FLUSH SHEAR HEAD, A286
CORROSION RESISTANT STEEL AND NICKEL-COPPER**

NAS1200
SHEET 1 OF 3

SHEET 1 OF 3

MATERIAL:

- (11) A286 (UNS S66286) - CORROSION AND HEAT RESISTANT WIRE PER AMS5734.
ALLOY WIRE - NICKEL-COPPER (UNS N04400) PER QQ-N-281, CLASS A (ANNEALED).

SHEAR STRENGTH AT ROOM TEMPERATURE /12/:

- A286 - 85 KSI TO 95 KSI AS HEAT TREATED.
90 KSI MIN AFTER DRIVING.
(11) NICKEL-COPPER - 49 KSI TO 59 KSI, AS RECEIVED.

HEAT TREAT:

A286 - SOLUTION TREAT AND PARTIALLY PRECIPITATION HEAT TREAT AFTER HEADING AS FOLLOWS:
HEAT AT 1650 °F ±25 °F 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.

FINISH:

- A286 - PASSIVATE PER AMS2700, METHOD 1, CLASS 4.
(11) NICKEL-COPPER - ONLY WHEN SPECIFIED, CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

CODE:

"M" IN PLACE OF FIRST DASH INDICATES NICKEL-COPPER. (11)
"P" AFTER LAST DASH NUMBER INDICATES CADMIUM PLATE FOR NICKEL-COPPER ONLY. (11)

EXAMPLES OF PART NUMBERS:

- (11) NAS1200-4-8 = .125 DIA, .500 LENGTH, A286 RIVET
NAS1200M4-8 = .125 DIA, .500 LENGTH, NICKEL-COPPER RIVET, NO FINISH
NAS1200M4-8P = .125 DIA, .500 LENGTH, NICKEL-COPPER RIVET, CADMIUM PLATED
NAS1200-4-8-5 = .125 DIA, .531 LENGTH, A286 RIVET /10/

NOTES:

- (1) TOLERANCES UNLESS OTHERWISE SPECIFIED: ±.010, ANGLES ±1°.
- (2) .001 SHANK DIAMETER INCREASE PERMISSIBLE WITHIN .10 INCHES 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.
- (5) RIVETS MUST BE OF UNIFORM QUALITY AND FREE FROM SCALE, FINS, SEAMS, CLINCH OR DIE MARKS, COLD SHUTS, OR OTHER INJURIOUS DEFECTS.
- (11) (6) HEAD COCKING ANGLE RELATIVE TO AXIS OF RIVET .5° 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) THE HEAD PERIPHERY MAY BE ROUNDED WITHIN THE "E" DIMENSION.

REVISION

11

NAS1200
SHEET 2



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