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FED. SUPPLY CLASS
5320

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ARLINGTON, VA 22209

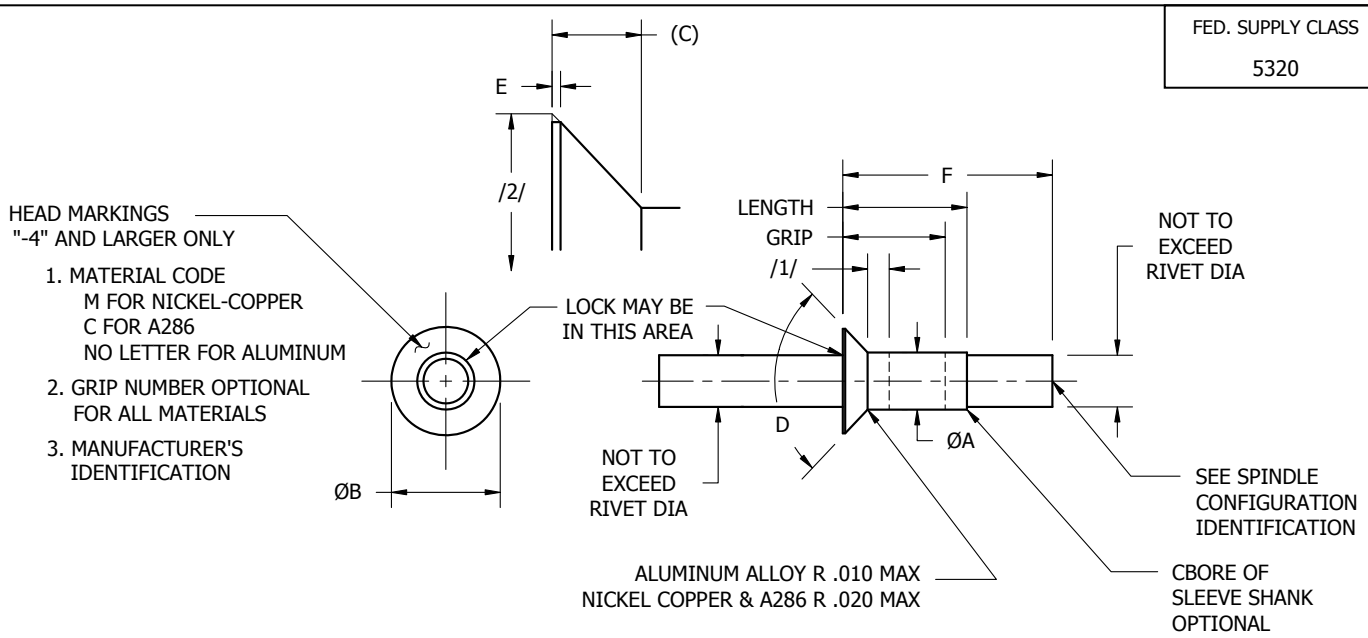
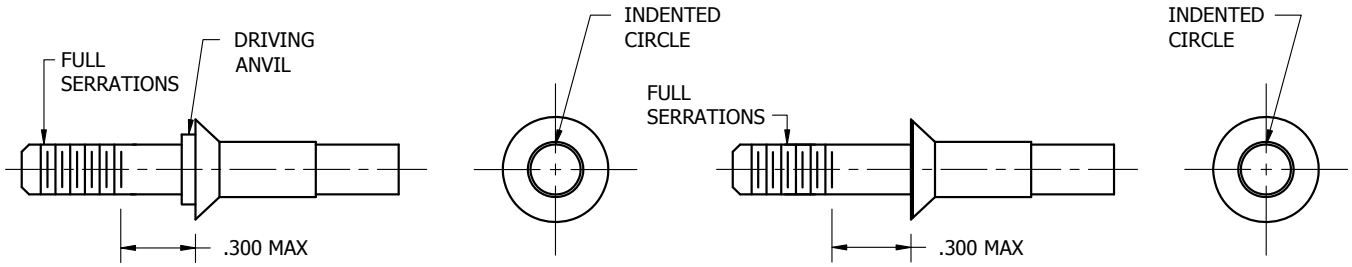


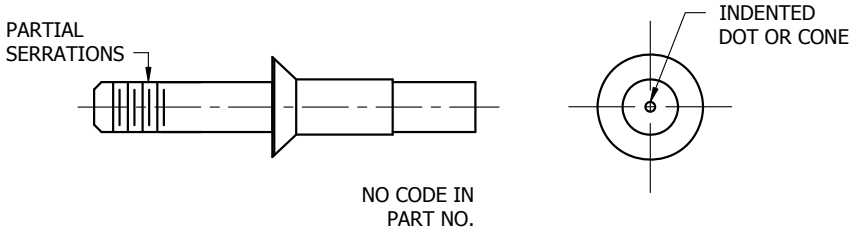
TABLE I – DIMENSIONS

RIVET DIAMETER NUMBER	RIVET SIZE NOMINAL DIAMETER	ØA +.003 −.001	ØB ±.004 /2/	(C)	D		E	
					ALUMINUM ALLOY	NICKEL-COPPER OR A286	ALUMINUM ALLOY	NICKEL-COPPER OR A286
3 /3/	.094	.094	.179	.036	100° ± 1°	100° ± 1.5°	.002–.010	.005–.015
4	.125	.125	.225	.042			.002–.010	
5	.156	.156	.286	.055			.002–.012	
6	.190	.187	.353	.070			.002–.012	
8	.250	.250	.476	.095			.002–.016	



CODE "AB" IN
PART NO.

CODE "A" IN
PART NO.



NO CODE IN
PART NO.

10 COMPLETELY REVISED

SPINDLE CONFIGURATION IDENTIFICATION

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.

REVISION DATE: JULY 31, 2012
ISSUE DATE: APRIL 1961

THIRD ANGLE PROJECTION	CUSTODIAN	REVISION
	NATIONAL AEROSPACE STANDARDS COMMITTEE	10
PROCUREMENT SPECIFICATION	TITLE	CLASSIFICATION PART STANDARD
NAS1400	RIVET, BLIND, 100° FLUSH HEAD, LOCKED SPINDLE (10)	NAS1399

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TABLE II – MATERIAL, FINISH, AND COLOR

	MATERIAL			FINISH			COLOR
BASIC PART NO.	SLEEVE	SPINDLE	LOCK RING /4/	SLEEVE	SPINDLE	LOCK RING /4/	SLEEVE
NAS1399B	5056-F (UNS A95056) PER QQ-A-430	7075 (UNS A97075) PER QQ-A-430	5056-H38 (UNS A95056) PER QQ-A-430	ANODIZE PER MIL-A-8625 OR CHEMICAL FILM PER MIL-DTL-5541 UNLESS SPECIFIED BY CODE LETTER "P" FOR ANODIZE ONLY OR CODE LETTER "FC" FOR CHEMICAL FILM ONLY		NONE	ORANGE SIMILAR TO FED-STD-595 COLOR NO. 32246
NAS1399D	2017-T4 (UNS A92017) PER QQ-A-430						NATURAL (AS PLATED AND/OR LUBRICATED)
NAS1399M	NICKEL-COPPER (UNS N04400) PER QQ-N-281	NICKEL-COPPER (UNS N04400) PER QQ-N-281 OR A286 (UNS S66286) PER AMS5731 OR AMS5732	NICKEL-COPPER (UNS N04400) PER QQ-N-281	NICKEL-COPPER: NONE A286: PASSIVATE PER AMS2700, METHOD 1, CLASS 4 UNLESS SPECIFIED BY CODE LETTER "W" FOR CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2; OR CODE LETTER "S" FOR SILVER PLATE PER ASTM B700 .0002 MIN THICK; OR CODE LETTER "FA" FOLLOWING MATERIAL CODE "C" ONLY FOR DRY FILM LUBE PER AS5272, TYPE I	NICKEL-COPPER: NONE A286: PASSIVATE PER AMS2700, METHOD 1, CLASS 4		
NAS1399C	A286 (UNS S66286) PER AMS5731, AMS5732 OR AMS5737	A286 (UNS S66286) PER AMS5731	NICKEL-COPPER (UNS N04400) PER QQ-N-281		PASSIVATE PER AMS2700, METHOD 1, CLASS 4		

CODE:

"B" AFTER BASIC PART NUMBER INDICATES 5056 ALUMINUM ALLOY SLEEVE
"D" AFTER BASIC PART NUMBER INDICATES 2017 ALUMINUM ALLOY SLEEVE
"M" AFTER BASIC PART NUMBER INDICATES NICKEL-COPPER SLEEVE
"C" AFTER BASIC PART NUMBER INDICATES A286 CRES SLEEVE
"FC" AFTER MATERIAL CODE LETTERS "B" OR "D" INDICATES CHEMICAL FILM FINISH ON SLEEVE AND SPINDLE
"P" AFTER MATERIAL CODE LETTERS "B" OR "D" INDICATES ANODIZE FINISH ON SLEEVE AND SPINDLE
"W" AFTER MATERIAL CODE LETTERS "M" OR "C" INDICATES CADMIUM-PLATED SLEEVE
"S" AFTER MATERIAL CODE LETTERS "M" OR "C" INDICATES SILVER-PLATED SLEEVE
"FA" AFTER MATERIAL CODE LETTER "C" INDICATES DRY FILM LUBED SLEEVE
"A" IN PLACE OF "-" BETWEEN DIAMETER AND GRIP INDICATES RIVET WITH FULL SERRATED SPINDLE
"AB" IN PLACE OF "-" BETWEEN DIAMETER AND GRIP INDICATES RIVET WITH FULL SERRATED SPINDLE & DRIVING ANVIL

EXAMPLES OF PART NUMBER:

NAS1399M4-4 = NICKEL-COPPER-ALLOY RIVET, Ø.125 WITH .188 TO .250 GRIP RANGE, NO FINISH ON SLEEVE, WITH PARTIAL SERRATED SPINDLE AND INDENTED DOT OR CONE IDENTIFICATION

NA51399B4-4 = 5056 ALUMINUM ALLOY RIVET, Ø.125 WITH .188 TO .250 GRIP RANGE, WITH PARTIAL SERRATED SPINDLE AND INDENTED DOT OR CONE IDENTIFICATION, FINISH OPTIONAL – CHEMICAL FILM OR ANODIZE, ORANGE COLORED SLEEVE

NAS1399MW4A4 = NICKEL-COPPER-ALLOY RIVET, Ø.125 WITH .188 TO .250 GRIP RANGE, CADMIUM-PLATED, WITH FULL SERRATED SPINDLE AND INDENTED CIRCLE IDENTIFICATION

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