

FED. SUPPLY CLASS

5320

HEAD MARKINGS
"-4" AND LARGER ONLY

1. MATERIAL CODE
M FOR NICKEL-COPPER
C FOR A286
NO LETTER FOR ALUMINUM
2. GRIP NUMBER OPTIONAL
FOR ALL MATERIALS
3. MANUFACTURER'S
IDENTIFICATION

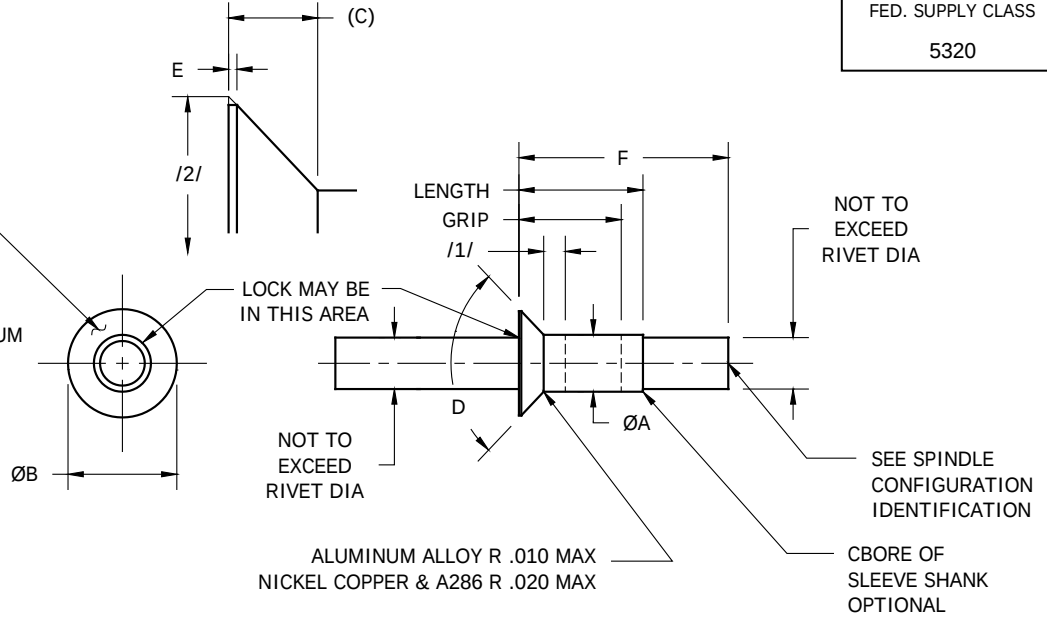
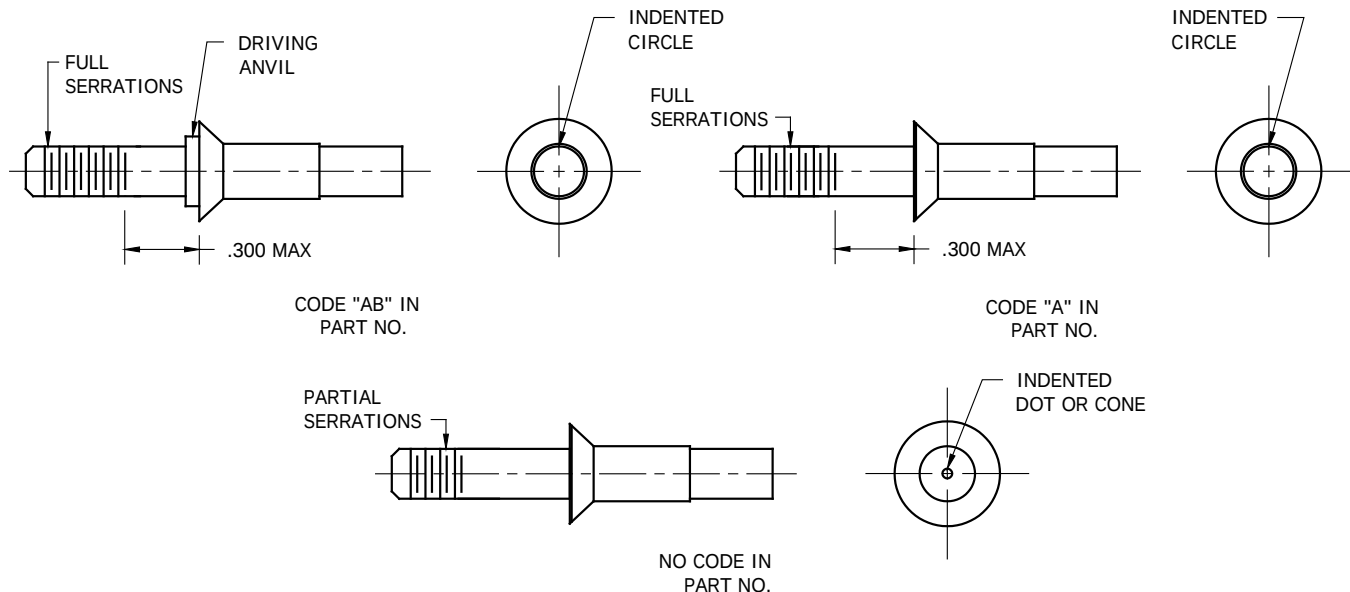


TABLE I – DIMENSIONS

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	



SPINDLE CONFIGURATION IDENTIFICATION

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 11
PROCUREMENT SPECIFICATION NAS1400	TITLE RIVET, BLIND, 100° FLUSH HEAD, LOCKED SPINDLE	CLASSIFICATION PART STANDARD



NAS1399
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TABLE II – MATERIAL, FINISH, AND COLOR ¹¹

BASIC PART NO.	MATERIAL			FINISH			COLOR
	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			ORANGE SIMILAR TO AMS-STD-595 COLOR NO. 32246
NAS1399D	2017-T4 (UNS A92017) PER QQ-A-430						
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 OR TYPE III			NATURAL (AS PLATED AND/OR LUBRICATED)
NAS1399C	A286 (UNS S66286) PER AMS5731, AMS5732 OR AMS5737	A286 (UNS S66286) PER AMS5731	NICKEL- COPPER (UNS N04400) PER QQ-N-281				

CODE:

¹¹

NAS1399 M W 4 A 4
BASIC NUMBER: _____ GRIP DASH NUMBER:
(TABLE III)

MATERIALS: _____ SPINDLE:
"B" = 5056 AL ALLOY SLEEVE
"D" = 2017 AL ALLOY SLEEVE
"M" = Ni-Cu SLEEVE
"C" = A286 CRES SLEEVE
"_" = WITH PARTIAL SERRATED SPINDLE
"A" = WITH FULL SERRATED SPINDLE
"AB" = WITH FULL SERRATED SPINDLE
AND DRIVING ANVIL

FINISH: _____ RIVET DIAMETER NUMBER:
(TABLE I)

NO CODE = SEE TABLE II
"FC" = FOR MATERIAL CODE "B" OR "D", CHEMICAL FILM FINISH ON SLEEVE AND SPINDLE
"P" = FOR MATERIAL CODE "B" OR "D", ANODIZE FINISH ON SLEEVE AND SPINDLE
"W" = FOR MATERIAL CODE "M" OR "C", CADMIUM PLATED SLEEVE
"S" = FOR MATERIAL CODE "M" OR "C", SILVER PLATED SLEEVE
"FA" = FOR MATERIAL CODE "C", DRY FILM LUBED SLEEVE

REVISION

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