

FED. SUPPLY CLASS

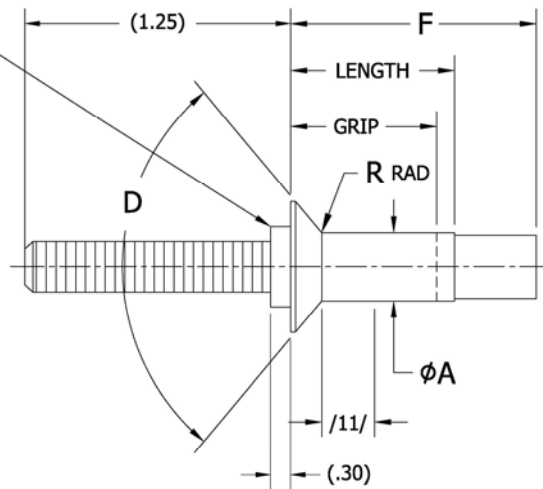
5320

FORMING ANVIL FOR
"L" CODED PARTS ONLY
-2/-

MANUFACTURER'S
IDENTIFICATION

MATERIAL CODE:

- NO LETTER FOR 2014A ALUMINUM
- ONE DOT FOR 7050 ALUMINUM
- TWO DOTS FOR A286 CRES



SEE TABLE IV
FOR BLIND-SIDE
CLEARANCE

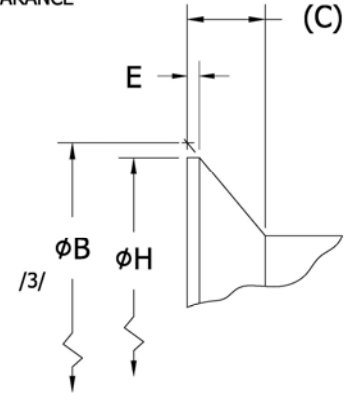


TABLE I – DIMENSIONS

RIVET DIAMETER NUMBER	RIVET DIAMETER NUMBER	RIVET SIZE NOMINAL DIAMETER	ØA +.004 -.001	ØB ±.004 /3/	(C)	ØH MIN
4L	4	.125	.125	.192	.029	.174
5L	5	.156	.156	.243	.037	.226
6L	6	.190	.188	.299	.046	.282

TABLE II – MATERIAL SPECIFIC DIMENSIONS

MATERIAL	D	E	R RAD MAX
AL. ALLOY	100° ± 1°	.002-.009	.010
A286	100° ± 1.5°	.005-.015	.020

MATERIAL:

SEE TABLE III.

FINISH

SEE TABLE III.

LUBRICATION:

SEE TABLE III.

④ COMPLETELY REVISED

THIRD ANGLE PROJECTION	
PROCUREMENT SPECIFICATION	NAS1722

CUSTODIAN	NATIONAL AEROSPACE STANDARDS COMMITTEE
TITLE	RIVET, BLIND, 100° REDUCED FLUSH HEAD, (NAS1097 HEAD), MECHANICALLY LOCKED SPINDLE

REVISION	4
CLASSIFICATION PART STANDARD	NAS1719
SHEET 1 OF 5	Document Sharing Hub

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

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.

FORM 12-01

REVISION DATE: JUNE 30, 2016
ISSUE DATE: JUNE 1987

CODE:

SEE MATERIALS AND FINISHES TABLE III.

AFTER BASIC PART NUMBER:

- /13/ ~~ADD "KE" INDICATES 7050 ALUMINUM ALLOY SLEEVE WITH ALUMINUM SPINDLE~~
 ADD "H" INDICATES 2014A ALUMINUM ALLOY SLEEVE WITH ALUMINUM SPINDLE
 ADD "C" INDICATES A286 CRES SLEEVE WITH CRES SPINDLE

AFTER DIAMETER:

- ADD "L" AFTER DIAMETER PROVIDES FORMING ANVIL (LOCK CREATOR)
 ADD "-" AFTER DIAMETER EXCLUDES FORMING ANVIL

AFTER SECOND DASH NUMBER:

~~NO LETTER AFTER SECOND DASH NUMBER INDICATES DICRONITE DL 5 ONLY SPACE COMPATIBLE LUBE PER~~
~~DD-L-85615 (INACTIVE FOR NEW DESIGN)~~

- ADD "A" INDICATES CLEAR ANODIZE OF ALUMINUM SLEEVE PER MIL-A-8625
 ADD "F" INDICATES CHEMICAL FILM TREATMENT OF ALUMINUM SLEEVE PER MIL-DTL-5541
 ADD "P" INDICATES PASSIVATION OF SLEEVE PER AMS2700, METHOD 1, CLASS 4.
 ADD "W" INDICATES CADMIUM PLATED SLEEVE PER AMS-QQ-P-416

AFTER FINISH CODE:

- ADD "N" AFTER FINISH CODE TO INDICATE NATURAL FINISH ON ALUMINUM SLEEVE
 /13/ ~~ADD "M" AFTER FINISH CODE TO INDICATE MOLYKOTE 106 SPACE COMPATIBLE LUBE PER~~
~~AS5272; NOT FOR USE WHEN POTENTIAL CONTACT WITH LOX EXISTS.~~

PART NUMBER EXAMPLE:

- ~~NAS1719KE4L4A = 7075 ALUMINUM ALLOY RIVET; Ø.125 WITH .172 TO .266 GRIP RANGE;~~
~~ANODIZED SLEEVE, WITH FORMING ANVIL~~
 NAS1719H4L6F = 2014A ALUMINUM ALLOY RIVET; Ø.125 WITH .297 TO .391 GRIP RANGE;
 CHEMICAL FILM ON SLEEVE, WITH FORMING ANVIL
 NAS1719C5-2P = A286 CRES RIVET; Ø.156 WITH .062 TO .141 GRIP; PASSIVATED SLEEVE;
 WITHOUT FORMING ANVIL
 NAS1719C5L6M = A286 CRES RIVET; Ø.156 WITH .297 TO .391 GRIP; PASSIVATED WITH
 MOLYKOTE 106 SPACE COMPATIBLE LUBE; WITH FORMING ANVIL

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC
 1000 WILSON BLVD.
 ARLINGTON, VA 22209

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.

FORM 12-01

REVISION

4

④ COMPLETELY REVISED



NAS1719
SHEET 2

Document Sharing Hub