

FED. SUPPLY CLASS

5320

GRIP NUMBER /8/
(SINGLE DIGIT
MARKING IS
PERMISSIBLE
FOR GRIP DASH
NUMBERS LESS
THAN 10)

MANUFACTURER'S
IDENTIFICATION

G

C

F

LENGTH

/4/

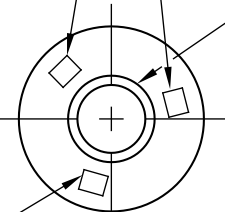
/7/

LOCK COLLAR MAY
BE IN THIS AREA

SPINDLE /9/

ØB

ØA



SLEEVE CODE:
BLANK - FOR 5056
CODE C - FOR A286
CODE M - NICKEL COPPER

HEAD MARKING /5/
(ARRANGEMENT OPTIONAL)

"U" CODE DRIVE ANVIL
WASHER FOR
SINGLE ACTION
"S" CODE RIVETS ONLY

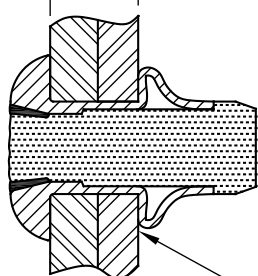
25°
MAX

R .020
MAX

COUNTERBORE OF SLEEVE
SHANK OPTIONAL

/9/

GRIP



BLIND SIDE HEAD MAY
BE INSTALLED ON 5°
MAXIMUM SLOPE

INSTALLED RIVET

TABLE I - DIMENSIONS

DIA DASH NUMBER	RIVET SIZE NOMINAL	ØA /6/ +.0035 -.001	ØB	C +.010 -.000	G MINIMUM
04	.125	.125	.250 ±.012	.054	.788
05	.156	.156	.312 ±.016	.067	.788
06	.190	.187	.375 ±.019	.080	.788
08	.250	.250	.500 ±.025	.107	1.000

⑧ COMPLETELY REVISED

THIRD
ANGLE
PROJECTION

PROCUREMENT
SPECIFICATION

NAS1900

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

TITLE

**RIVET, BLIND, GENERAL PURPOSE, BULBED,
PROTRUDING HEAD, MECHANICALLY-LOCKED-SPINDLE**

REVISION

8

CLASSIFICATION
PART STANDARD

NAS1919
SHEET 1 OF 5

Document Sharing Hub

TABLE II – MATERIALS AND FINISHES

RIVET COMPONENTS	COMPOSITION B	COMPOSITION C	COMPOSITION M
MATERIALS			
SLEEVE	5056 (UNS A95056) ALUMINUM PER QQ-A-430	A286 CRES (UNS S66286) PER CHEMISTRY REQUIREMENTS OF AMS5737	NICKEL-COPPER (UNS N04400) PER QQ-N-281
SPINDLE	2024 (UNS A92024) ALUMINUM PER QQ-A-430	A286 CRES (UNS S66286) PER CHEMISTRY REQUIREMENTS OF AMS5737	A286 CRES (UNS S66286) PER CHEMISTRY REQUIREMENTS OF AMS5737
LOCK RING	5056 (UNS A95056) ALUMINUM PER QQ-A-430	A286 CRES (UNS S66286) PER CHEMISTRY REQUIREMENTS OF AMS5737 OR 316 CRES (UNS S31600) PER AMS5690	A286 CRES (UNS S66286) PER CHEMISTRY L REQUIREMENTS OF AMS5737, NICKEL-COPPER (UNS N04400) PER CHEMISTRY REQUIREMENTS OF QQ-N-281 OR 316 CRES (UNS S31600) PER AMS5690
FINISHES			
SLEEVE	NONE OR CHEMICAL FILM TREAT PER MIL-DTL-5541, CL 1A	PASSIVATE PER AMS2700, METHOD 1, CLASS 4 OR CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CL 3 OR AL COATING PER NAS4006	NONE OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CL 3 OR AL COATING PER NAS4006
SPINDLE	CHEMICAL FILM TREAT PER MIL-DTL-5541, CL 1A	PASSIVATE PER AMS2700, METHOD 1, CLASS 4	PASSIVATE PER AMS2700, METHOD 1, CLASS 4
LOCK RING	NONE OR CHEMICAL FILM TREAT PER MIL-DTL-5541, CL 1A	PASSIVATE PER AMS2700, METHOD 1, CLASS 4	PASSIVATE PER AMS2700, METHOD 1, CLASS 4 FOR CRES ONLY

CODE: DIA NUMBER DESIGNATES DIAMETER IN .0312 INCREMENTS.
 GRIP DASH NUMBER DESIGNATES MAXIMUM GRIP IN .0625 INCREMENTS.
 ADD "A" AFTER SECOND DASH NUMBER FOR ALUMINUM COATING PER NAS4006.
 ADD "B" AFTER BASIC NUMBER FOR COMPOSITION B ALUMINUM RIVET.
 ADD "C" AFTER BASIC NUMBER FOR COMPOSITION C A286 CRES RIVET.
 ADD "M" AFTER BASIC NUMBER FOR COMPOSITION M NICKEL-COPPER RIVET.
 ADD "P" AFTER SECOND DASH NUMBER TO DESIGNATE RIVET MAY BE SLOSH CLEANED WITH A-A-59281
 MIL-C-38736 CLEANER BEFORE INSTALLATION. RIVETS MAY BE LUBRICATED OR NON-LUBRICATED AT
 OPTION OF MANUFACTURER.
 ADD "S" AFTER FIRST DASH NUMBER TO DESIGNATE RIVET FOR USE WITH SINGLE ACTION (NON-SHIFTING) HAND
 HELD INSTALLATION TOOLS OR IN AUTOMATED INSTALLATION EQUIPMENT. /9/
 ADD "U" AFTER SECOND DASH NUMBER TO DESIGNATE RIVET UTILIZING DRIVE ANVIL WASHER AS PART OF RIVET
 ASSEMBLY. WASHER ALLOWS USE OF BLUNT NOSED INSTALLATION TOOLING. AVAILABLE WITH "S" CODE
 ONLY.
 ADD "W" AFTER SECOND DASH NUMBER FOR CADMIUM PLATED RIVET SLEEVE.
 ADD "FC" AFTER SECOND DASH NUMBER FOR COMPOSITION B RIVETS TO SPECIFY CHEMICAL FILM TREATMENT
 PER MIL-DTL-5541, CL 1A.

⑧ COMPLETELY REVISED

REVISION

8

NAS1919
SHEET 2



Document Sharing Hub

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY

Copyright Aerospace Industries Association of America, Inc. AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF
 Provided by IHS under license with AIA/NAS. Licensee: www.sepana.ir/5991803002, User=sam, albert
 No reproduction or networking permitted without license from IHS. Not for Resale, 01/04/2016 22:33:26 MST. TRADEMARKS RIGHTS.

Full document details: AIA NAS1919 2011