

ISSUE DATE: APRIL 1972

FED. SUPPLY CLASS

5320

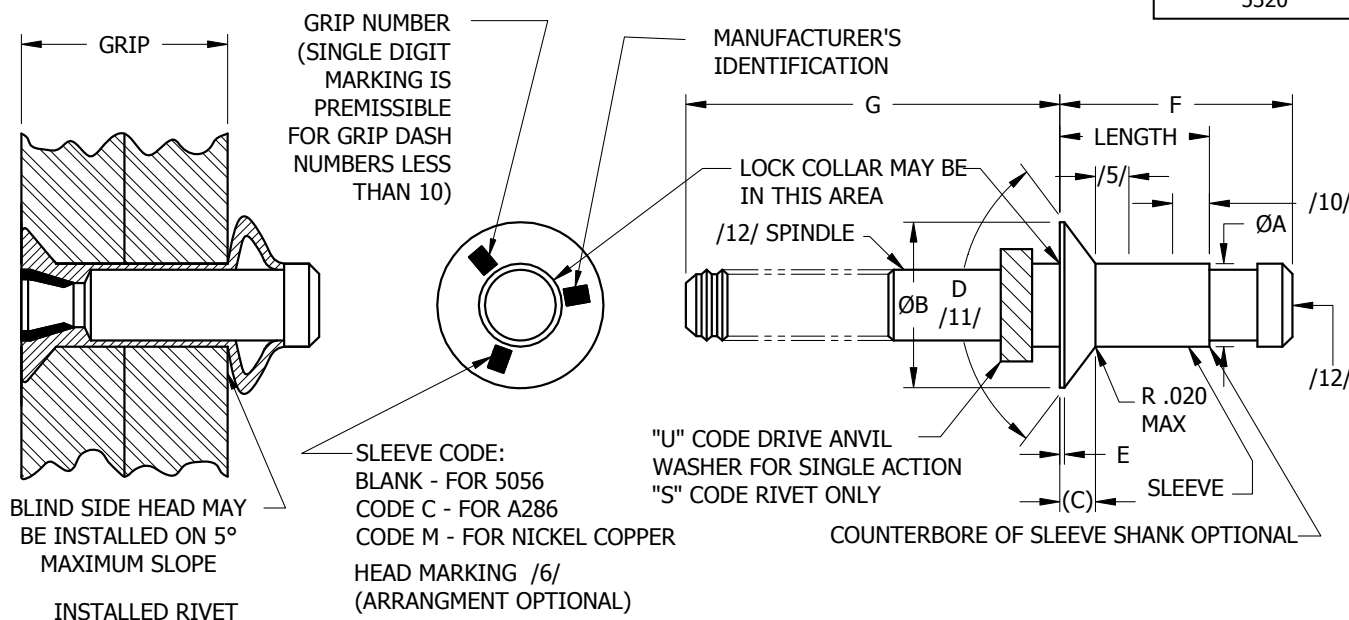


TABLE I – DASH NUMBERS & DIMENSIONS

DIAMETER DASH NUMBER	RIVET SIZE NOMINAL	ØA +.0035 -.001 /7/	ØB ± .004 /8/	(C)	D /11/		E AL ALLOY, A286, & NICKEL-COPPER	G MIN
					AL ALLOY	A286 & NICKEL-COPPER		
04	.125	.125	.225	.042	100° ± 1.0°	100° ± 1.5°	.002 TO .015	.788
05	.156	.156	.286	.055				.788
06	.190	.187	.353	.070				.788
08	.250	.250	.476	.095				1.000

MATERIAL :

SLEEVE:

COMPOSITION B: 5056 (UNS A95056) ALUMINUM PER QQ-A-430.
COMPOSITION C: A286 CRES (UNS S66286) PER CHEMICAL REQUIREMENTS OF AMS5737.
COMPOSITION M: NICKEL-COPPER (UNS N04400) PER QQ-N-281.

SPINDLE:

COMPOSITION B: 2024 (UNS A92024) ALUMINUM PER QQ-A-430.
COMPOSITION C & M: A286 CRES (UNS S66286) PER CHEMICAL REQUIREMENTS OF AMS5737.

LOCK RING:

COMPOSITION B: 5056 (UNS A95056) ALUMINUM PER QQ-A-430.
COMPOSITION C: A286 CRES (UNS S66286) PER CHEMICAL REQUIREMENTS OF AMS5737 OR 316 CRES (UNS S31600) PER AMS5690.
COMPOSITION M: A286 CRES (UNS S66286) PER CHEMICAL REQUIREMENTS OF AMS5737, NICKEL-COPPER (UNS N04400) PER CHEMICAL REQUIREMENTS OF QQ-N-281, OR 316 CRES (UNS S31600) PER AMS5690.

⑨ COMPLETELY REVISED



CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

9

PROCUREMENT SPECIFICATION

TITLE

NAS1900

**RIVET, BLIND, GENERAL PURPOSE, BULBED,
100° FLUSH HEAD, MECHANICALLY-LOCKED-SPINDLE**

NAS1921
SHEET 1 OF 4

SHEET 1 OF 4

FINISH:

SLEEVE:

COMPOSITION B: NONE OR CHEMICAL FILM TREAT PER MIL-DTL-5541 CLASS 1A.

COMPOSITION C: PASSIVATE PER AMS2700, METHOD 1, CLASS 4,
CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 3, OR
ALUMINUM COATING PER NAS4006.

COMPOSITION M: NONE OR CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 3, OR
ALUMINUM COATING PER NAS4006.

SPINDLE:

COMPOSITION B: CHEMICAL FILM TREAT PER MIL-DTL-5541 CLASS 1A.

COMPOSITION C & M: PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

LOCK RING:

COMPOSITION B: NONE OR CHEMICAL FILM TREAT PER MIL-DTL-5541 CLASS 1A.

COMPOSITION C: PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

COMPOSITION M: PASSIVATE PER AMS2700, METHOD 1, CLASS 4 FOR CRES ONLY.

CODE:

FIRST DASH NUMBER DESIGNATES DIAMETER IN .0312 INCREMENTS.

SECOND 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

~~MIL-C-38736~~ A-A-59281 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. /12/

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 CLASS 1A.

EXAMPLES OF PART NUMBER:

NAS1921B05-04 = 5056 ALUMINUM RIVET, Ø.156, .188 TO .250 GRIP RANGE, NO FINISH ON
SLEEVE OR LOCK RING.

NAS1921B05-04FC = 5056 ALUMINUM RIVET, Ø.156, .188 TO .250 GRIP RANGE, CHEMICAL FILM
TREAT ALL COMPONENTS PER MIL-DTL-5541, CLASS 1A.

NAS1921C05-04 = A286 CRES RIVET, Ø.156, .188 TO .250 GRIP RANGE, PASSIVATED FINISH.

NAS1921C05-04W = A286 CRES RIVET, Ø.156, .188 TO .250 GRIP RANGE, CADMIUM PLATED
SLEEVE.

NAS1921M05-04 = NICKEL-COPPER RIVET, Ø.156, .188 TO .250 GRIP RANGE, UNPLATED SLEEVE.

NAS1921M05-04W = NICKEL-COPPER RIVET, Ø.156, .188 TO .250 GRIP RANGE, CADMIUM PLATED
SLEEVE.

NAS1921M05-04A = NICKEL-COPPER RIVET, Ø.156, .188 TO .250 GRIP RANGE, ALUMINUM COATED
SLEEVE.

REVISION

9

⑨ COMPLETELY REVISED



nas1921

SHEET 2

Document Sharing Hub