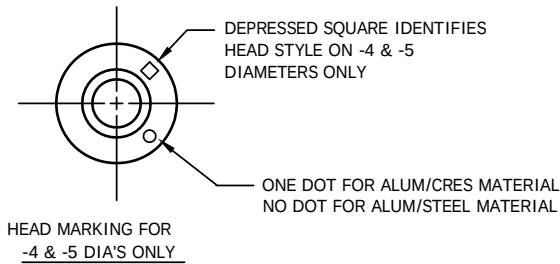


FED. SUPPLY CLASS

5320



CODE " + " FOR CRES SPINDLE MATERIAL

LOCK RING IN THIS AREA AFTER INSTALLATION FOR VISIBLE LOCK TYPE RIVETS /4/

GRIP LENGTH DASH NUMBER

SPINDLE /9/



HEAD MARKING FOR -8 DIA ONLY

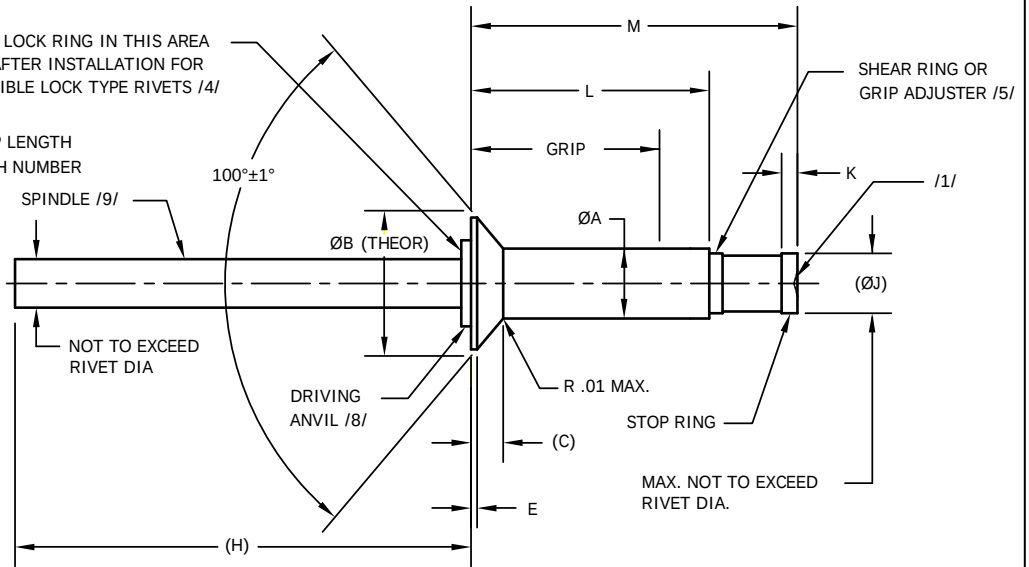


TABLE I - DIMENSIONS

DIAMETER DASH NUMBER	RIVET NOMINAL DIAMETER	ØA +.003 - .001	ØB (THEOR) ±.004	(C)	E		(H)	(ØJ)	K MIN	HOLE LIMITS	
					MAX	MIN				MAX	MIN
4	.125	.126	.192	.028	.010	.002	.87	.100	.010	.132	.129
5	.156	.157	.243	.037	.012	.002	.94	.125	.015	.164	.160
6	.190	.189	.299	.046	.012	.002	.94	.155	.015	.196	.192

MATERIAL: SEE TABLE II.

FINISH: SEE TABLE II.

CODE: ADD LETTER "B" AFTER BASIC PART NUMBER TO INDICATE 5056 ALUMINUM ALLOY SLEEVE AND 8740 ALLOY STEEL SPINDLE.
ADD LETTER "E" AFTER BASIC PART NUMBER TO INDICATE 5056 ALUMINUM ALLOY SLEEVE AND PH15-7 Mo CRES OR A286 CRES SPINDLE.
NO LETTER CODE AFTER RIVET MATERIAL CODE ("B" OR "E") TO INDICATE VISIBLE LOCK TYPE.
ADD LETTER "H" AFTER RIVET MATERIAL CODE ("B" OR "E") TO INDICATE INTERNAL LOCK TYPE.
ADD LETTERS "NS" AFTER RIVET MATERIAL CODE ("B" OR "E") TO INDICATE NO PREFERENCE TO LOCK TYPE (MAY BE VISIBLE OR INTERNAL).

⑥ COMPLETELY REVISED

THIRD ANGLE PROJECTION		CUSTODIAN		REVISION	
		NATIONAL AEROSPACE STANDARDS COMMITTEE		6	
		TITLE		CLASSIFICATION	
PROCUREMENT SPECIFICATION	NAS1686	RIVET, BLIND, 100° FLUSH SHEAR HEAD, MECHANICALLY LOCKED SPINDLE, BULBED STYLE A, CLASS 3, CODE B AND E		PART STANDARD	
				NAS9303	



Documents
SHEET 1 OF 3

TABLE II – MATERIAL AND FINISH

RIVET CODE		B	E
MATERIAL /2/	SLEEVE	ALUMINUM ALLOY - 5056 (UNS A95056) PER QQ-A-430	ALUMINUM ALLOY - 5056 (UNS A95056) PER QQ-A-430
	SPINDLE	ALLOY STEEL - 8740 (UNS G87400) PER AMS6322	CRES - PH15-7 Mo (UNS S15700) PER AMS5657, OR A286 (UNS S66286) PER AMS5737
	LOCKRING /4/	CRES - A286 (UNS S66286) PER AMS5731, OR 304 (UNS S30400) PER AMS5639	CRES - A286 (UNS S66286) PER AMS5731, OR 304 (UNS S30400) PER AMS5639
	GRIP ADJUSTER /5/	STEEL - C-1038 (UNS G10380)	CRES - A286 (UNS S66286) PER AMS5737, 300 SERIES PER ASTM A493 STEEL - C-1038 (UNS G10380)
FINISH	SLEEVE	MIL-DTL-5541, TYPE I, CLASS 1A PLAIN COLOR	MIL-DTL-5541, TYPE I, CLASS 1A PLAIN COLOR
	SPINDLE	CAD PLATE PER AMS-QQ-P-416, TYPE II, CL 2	(6) CAD PLATE PER QQ-P-416 TYPE I, CL 2 OR PASSIVATE PER AMS2700, METHOD 1, TYPE 2 OR 8, CLASS 1
	LOCKRING /4/	A286 - PASSIVATE PER AMS2700, METHOD 1, TYPE 2 OR 8, CLASS 1 304 - PASSIVATE PER AMS2700, METHOD 1, TYPE 2 OR 7, CLASS 1	A286 - PASSIVATE PER AMS2700, METHOD 1, TYPE 2 OR 8, CLASS 1 304 - PASSIVATE PER AMS2700, METHOD 1, TYPE 2 OR 7, CLASS 1
	GRIP ADJUSTER /5/	CAD PLATE PER AMS-QQ-P-416, TYPE II, CL 2	A286 - PASSIVATE PER AMS2700, METHOD 1, TYPE 2 OR 8, CLASS 1 300 SERIES - PASSIVATE PER AMS2700, METHOD 1, TYPE 2 OR 7, CLASS 1 STEEL - CAD PLATE PER AMS-QQ-P-416, TYPE II, CL2

EXAMPLE OF PART NUMBER:

- NAS93032B-4-05 = BLIND RIVET, NOMINAL SHANK DIA., 100° FLUSH SHEAR HEAD, 5056 ALUMINUM SLEEVE, 8740 ALLOY STEEL SPINDLE, VISIBLE LOCK TYPE, .125 NOMINAL RIVET DIAMETER, .251 TO .312 GRIP RANGE.
- NAS9303BH-4-05 = BLIND RIVET, NOMINAL SHANK DIA., 100° FLUSH SHEAR HEAD, 5056 ALUMINUM SLEEVE, 8740 ALLOY STEEL SPINDLE, INTERNAL LOCK TYPE, .125 NOMINAL RIVET DIAMETER, .251 TO .312 GRIP RANGE.
- NAS9303BNS-4-05 = BLIND RIVET, NOMINAL SHANK DIA., 100° FLUSH SHEAR HEAD, 5056 ALUMINUM SLEEVE, 8740 ALLOY STEEL SPINDLE, EITHER VISIBLE OR INTERNAL LOCK TYPE, .125 NOMINAL RIVET DIAMETER, .251 TO .312 GRIP RANGE.
- NAS9303E-5-06 = BLIND RIVET, NOMINAL SHANK DIA., 100° FLUSH SHEAR HEAD, 5056 ALUMINUM SLEEVE, PH15-7 Mo OR A286 CRES SPINDLE, VISIBLE LOCK TYPE, .156 NOMINAL RIVET DIAMETER, .313 TO .375 GRIP RANGE.
- NAS9303EH-5-06 = BLIND RIVET, NOMINAL SHANK DIA., 100° FLUSH SHEAR HEAD, 5056 ALUMINUM SLEEVE, A286 CRES SPINDLE, INTERNAL LOCK TYPE, .156 NOMINAL RIVET DIAMETER, .313 TO .375 GRIP RANGE.
- NAS9303ENS-6-07 = BLIND RIVET, NOMINAL SHANK DIA., 100° FLUSH SHEAR HEAD, 5056 ALUMINUM SLEEVE, PH15-7 Mo OR A286 CRES SPINDLE, EITHER VISIBLE OR INTERNAL LOCK TYPE, .190 NOMINAL RIVET DIAMETER, .376 TO .437 GRIP RANGE.

NOTES:

- /1/ SPINDLE END CONFIGURATION AND MARKING: FOR ALL LOCK TYPE CODES, END OF SPINDLE MAY BE FLAT, OR SLIGHTLY CONCAVE OR CONVEX. RIVETS USING THE INTERNAL LOCK FEATURE (BOTH "H" AND "NS" CODE AS APPLICABLE) SHALL BE IDENTIFIED WITH A LETTER "H" ON END OF SPINDLE. NO MARKING IS REQUIRED FOR VISIBLE LOCK TYPE (NO LETTER CODE AND "NS CODE" AS APPLICABLE.).

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REVISION
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NAS9303
SHEET 2



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