

FED. SUPPLY CLASS

5320

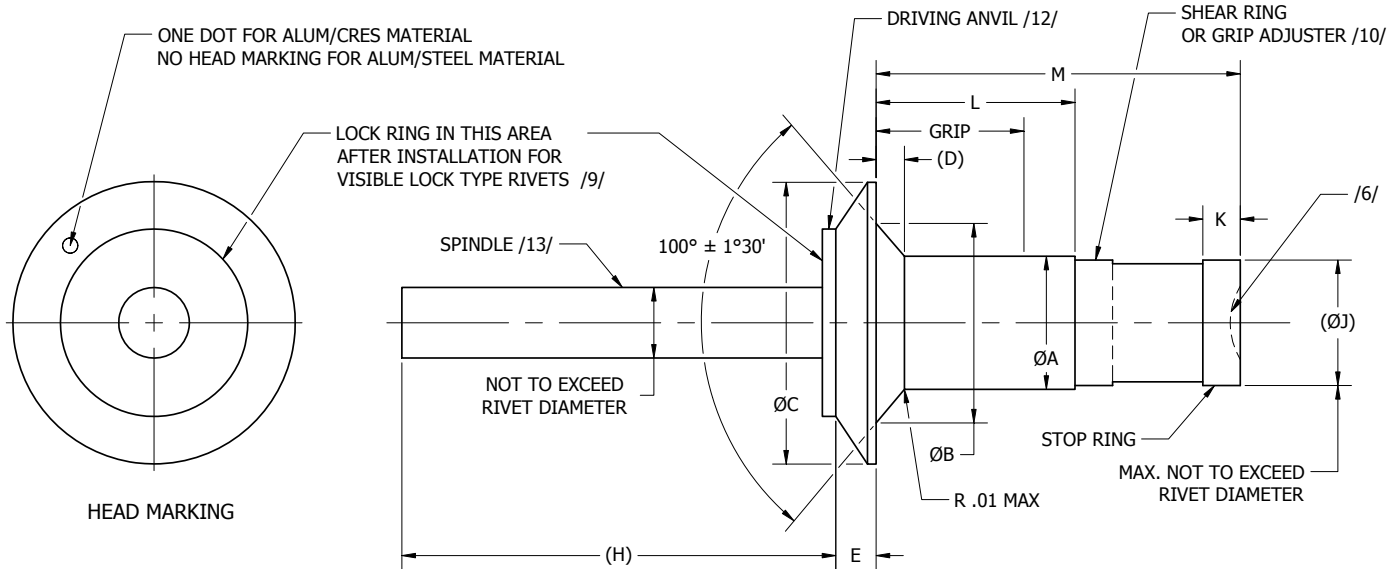


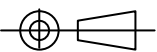
TABLE I – DIMENSIONS

DIAMETER DASH NUMBER	RIVET SIZE NOMINAL DIAMETER	ØA +.003 -.001	ØB ±.005	ØC ±.010	(D)	E +.010 -.000	(H)	(ØJ)	K MIN	HOLE LIMITS MIN/MAX
4	.125	.140	.165	.220	.011	.022	.87	.115	.010	.143/.146
5	.156	.173	.208	.286	.015	.030	.94	.140	.015	.176/.180
6	.190	.201	.255	.353	.023	.040	.94	.160	.015	.205/.209

TABLE II – MATERIAL AND FINISH

RIVET MATERIAL CODE	MATERIAL /7/				FINISH /8/			
	SLEEVE	SPINDLE	LOCKRING /9/	GRIP ADJUSTER /10/	SLEEVE	SPINDLE	LOCKRING /9/	GRIP ADJUSTER /10/
B	5056 ALUMINUM ALLOY PER QQ-A-430 (UNS A95056)	8740 ALLOY STEEL PER AMS6322 (UNS G87400)	A286 CRES PER AMS5731 (UNS S66286) OR 304 CRES PER AMS5839 (UNS S30400)	C-1038 STEEL	FINISH PER MIL-DTL-5541 PLAIN COLOR CLASS 1A	CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CL 2	PASSIVATE PER AMS2700, METHOD 1, CLASS 4	CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CL 2
E	5056 ALUMINUM ALLOY PER QQ-A-430 (UNS A95056)	PH15-7 Mo CRES PER AMS5657 (UNS S15700) OR A286 CRES PER AMS5737 (UNS S66286)	A286 CRES PER AMS 5731 (UNS S66286) OR 304 CRES PER AMS5839 (UNS S30400)	A286 CRES PER AMS5737 (UNS S66286) OR 300 SERIES CRES PER ASTM A493	FINISH PER MIL-DTL-5541 PLAIN COLOR CLASS 1A	CADMIUM PLATE PER AMS-QQ-P-416 TYPE I, CL 2 OR PASSIVATE PER AMS2700, METHOD 1, CLASS 4 /11/	PASSIVATE PER AMS2700, METHOD 1, CLASS 4	PASSIVATE PER AMS2700, METHOD 1, CLASS 4

THIRD
ANGLE
PROJECTION



CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

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PROCUREMENT
SPECIFICATION

NAS1686

TITLE

**RIVET, BLIND, FLANGED DOME HEAD,
MECHANICALLY LOCKED SPINDLE,
BULBED STYLE B, CLASS 4, CODE B AND E**

CLASSIFICATION
PART STANDARD



NAS1686

SHEET 1 OF 3

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TABLE III – GRIP LENGTHS AND DASH NUMBERS

STYLE B, CLASS 4, CODE B & E										
GRIP LIMITS .0625 RANGE		(-4) Ø.125			(-5) Ø.156			(-6) Ø.190		
MIN.	MAX.	DIA-GRIP DASH NUMBER	L +.000 -.030	M MAX	DIA-GRIP DASH NUMBER	L +.000 -.030	M MAX	DIA-GRIP DASH NUMBER	L +.000 -.030	M MAX
.033	.062	4-01	.170	.390	—	—	—	—	—	—
.063	.125	4-02	.213	.430	5-02	.246	.460	6-02	.265	.500
.126	.187	4-03	.276	.500	5-03	.309	.520	6-03	.328	.560
.188	.250	4-04	.338	.560	5-04	.371	.590	6-04	.390	.620
.251	.312	4-05	.401	.620	5-05	.434	.650	6-05	.453	.680
.313	.375	4-06	.463	.680	5-06	.496	.710	6-06	.515	.750
.376	.437	4-07	.526	.740	5-07	.559	.770	6-07	.578	.810
.438	.500	4-08	.588	.800	5-08	.621	.830	6-08	.640	.870

CODES:

RIVET MATERIAL 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 OR A286 CRES SPINDLE.

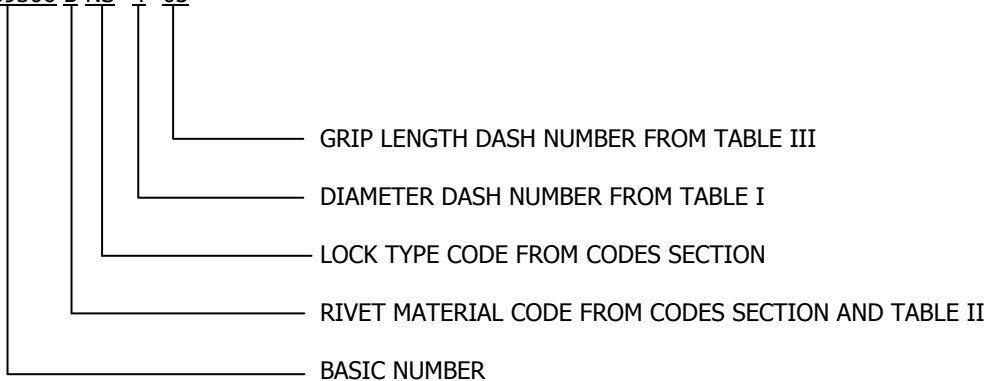
LOCK TYPE CODE:

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).

NAS9306 B NS-4-03



EXAMPLE OF PART NUMBER:

NAS9306B-4-05 = BLIND RIVET, OVERSIZE SHANK DIAMETER, FLANGED DOME HEAD, 5056 ALUMINUM SLEEVE, 8740 ALLOY STEEL SPINDLE, VISIBLE LOCK TYPE, .125 NOMINAL RIVET DIAMETER, .251 TO .312 GRIP RANGE.

REVISION

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Documents

SHEET 2

SHEET 2