

FED. SUPPLY CLASS

5320

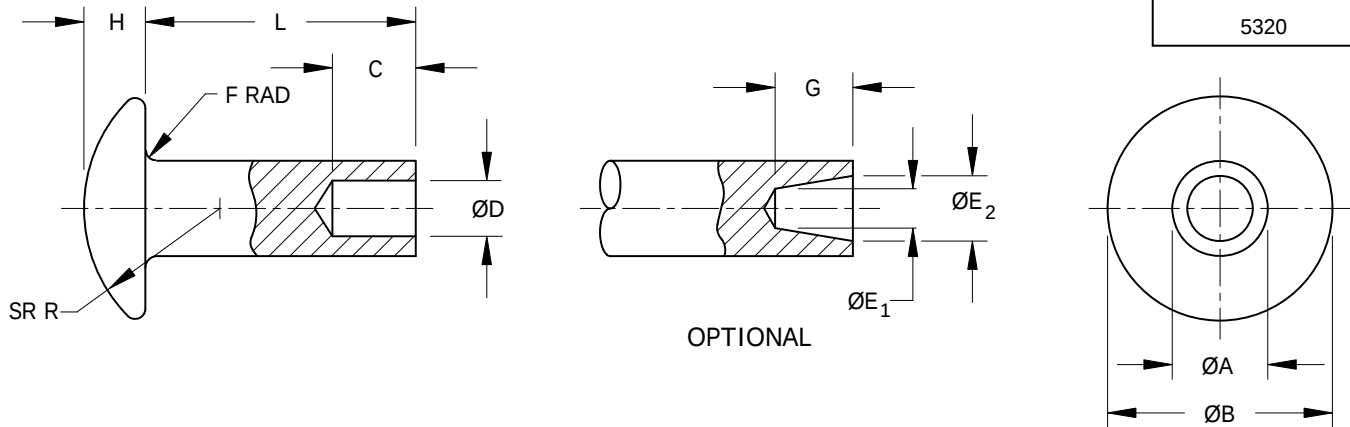


TABLE I – DIMENSIONS

NOM SIZE	ØA BODY		ØB HEAD		H HEAD THKNS		ØD STRAIGHT HOLE		ØE ₁ TAPER AT BOTTOM OF HOLE	ØE ₂ TAPER AT END OF RIVET		F RAD FILLET MAX	G HOLE DEPTH (TAPER) MIN	C HOLE DEPTH (STRAIGHT) NOM	SR R APPROX	CLINCH ALLOWANCE /1/
	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MIN	MAX	MIN					
.061	.061	.058	.114	.104	.019	.015	.044	.039	.032	.046	.042	.008	.042	.046	.160	.037
.089	.089	.085	.152	.142	.026	.020	.068	.062	.050	.068	.064	.012	.057	.064	.220	.064
.123	.123	.118	.223	.213	.038	.030	.090	.084	.079	.095	.091	.016	.082	.094	.310	.074
.146	.146	.141	.239	.229	.045	.035	.107	.100	.085	.112	.106	.020	.104	.126	.270	.089
.188	.188	.182	.318	.306	.055	.065	.141	.134	.110	.145	.139	.025	.135	.155	.250	.120

MATERIAL:

STEEL, CARBON, COMPOSITION 1005 THRU 1022 (UNS G10050 THRU G10200), IN ACCORDANCE WITH ASTM A29/A29M.

BRASS 1/8 TO 1/4 HARD, COMPOSITION 260 OR 270, (UNS C26000 OR UNS C27000), IN ACCORDANCE WITH QQ-W-321 ASTM B134/B134M.

ALUMINUM ALLOY, COMPOSITION 2117-T4 OR 5056-H32, (UNS A92117 OR UNS A95056), IN ACCORDANCE WITH QQ-A-430.

NICKEL-COPPER ALLOY (NICKEL-COPPER), CLASS A, NO. 0 TEMPER, (UNS N04400), IN ACCORDANCE WITH QQ-N-281.

COPPER, TYPE S, (UNS C10200), IN ACCORDANCE WITH QQ-W-343 A-A-59551.

CRES, CLASS 302, 304, OR 305 (UNS S30200, UNS S30400, OR UNS S30500) IN ACCORDANCE WITH AMS-QQ-S-763.

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS16535, REVISION J. PART NUMBERS REMAIN MS16535.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION FF-R-556	TITLE RIVET, TUBULAR, OVAL HEAD	CLASSIFICATION PART STANDARD MSM16535
		SHEET 1 OF 5

FINISH:

STEEL, CARBON, CADMIUM PLATED, TYPE II, CLASS 2, IN ACCORDANCE WITH AMS-QQ-P-416.
BRASS, BLACK (OXIDE) FINISH, IN ACCORDANCE WITH MIL-F-495, OR NICKEL PLATING, CLASS 1,
FULLY BRIGHT, .0002 THICK, IN ACCORDANCE WITH AMS-QQ-N-290.
ALUMINUM ALLOY, COMPOSITIONS 2117-T4 AND 5056-H32, ANODIZED IN ACCORDANCE WITH
MIL-A-8625 OR CHEMICAL CONVERSION COATING PER MIL-DTL-5541.
CRES, PASSIVATED IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.

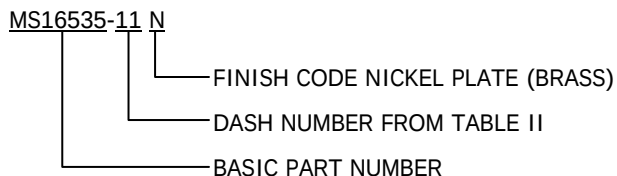
DOUBLE SHEAR STRENGTH:

CARBON STEEL RIVETS	32 KSI MIN
BRASS RIVETS	35 KSI MIN
ALUMINUM RIVETS (2117)	26 KSI MIN
ALUMINUM RIVETS (5056)	24 KSI MIN
NICKEL ALLOY (NICKEL-COPPER) RIVETS	49 KSI MIN
COPPER RIVETS	24 KSI MIN
CRES RIVETS	65 KSI MIN

CODE:

THE PART NUMBER SHALL CONSIST OF THE BASIC PART NUMBER FOLLOWED BY A DASH NUMBER
TAKEN FROM TABLE II.
ADD "N" AS A SUFFIX TO DASH NUMBER FOR NICKEL PLATING TO BRASS MATERIAL.
ADD "A" IN LIEU OF DASH FOR ALUMINUM ALLOY, COMPOSITION 5056-H32.

EXAMPLES OF PART NUMBERS:



MS16535-1	=	RIVET, CARBON STEEL, CADMIUM PLATED
MS16535-11	=	RIVET, BRASS, BLACK OXIDE FINISH
MS16535-11N	=	RIVET, BRASS, NICKEL PLATE FINISH
MS16535-21	=	RIVET, ALUMINUM ALLOY, 2117-T4, ANODIZE OR CHEMICAL FILM FINISH
MS16535A21	=	RIVET, ALUMINUM ALLOY, 5058-H32, ANODIZE OR CHEMICAL FILM FINISH
MS16535-424	=	RIVET, CRES, PASSIVATED

NOTES:

- /1/ CLINCH ALLOWANCE FOR REFERENCE ONLY. OPTIMUM VALUES VARY WITH CHARACTERISTICS OF MATERIALS TO BE RIVETED, AND SHOULD BE DETERMINED BY ACTUAL TEST IF POSSIBLE.
- (2) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (3) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

① COMPLETELY REVISED

REVISION
1
NAS 16535
SHEET 2

