

FED. SUPPLY CLASS

5320

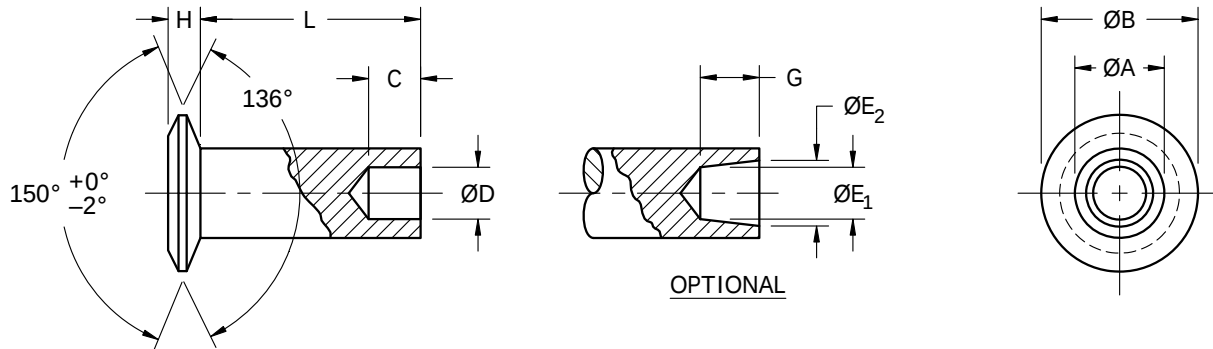


TABLE I – DIMENSIONS

NOM SIZE	ØA BODY		ØB HEAD		H HEAD THICKNESS		ØD STRAIGHT HOLE		ØE ₁ TAPER AT BOTTOM OF HOLE		ØE ₂ TAPER AT END OF RIVET		G HOLE DEPTH (TAPER)	C HOLE DEPTH (STRAIGHT) NOM	CLINCH ALLOWANCE /1/
	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN		
.123	.118	.123	.245	.255	.030	.038	.084	.090	.079	.091	.095	.082	.082	.094	.074
.146	.141	.146	.289	.303	.035	.045	.099	.105	.085	.106	.112	.104	.104	.126	.088
.188	.182	.188	.351	.367	.041	.051	.133	.139	.110	.139	.145	.135	.135	.155	.120
.252	.244	.252	.458	.478	.053	.067	.173	.183	.150	.181	.191	.183	.183	.219	.164

MATERIAL:

STEEL, CARBON C1005 THRU C1022 (UNS G10050 THRU G10220) PER FEDERAL STANDARD NO. 66 AIR4127.

BRASS, 260 (UNS C26000) OR 270 (UNS C27000), QUARTER HARD, PER QQ-W-321 ASTM B134/B134M.

ALUMINUM ALLOY, 2117-T4 (UNS A92117) OR 5056-H32 (UNS A95056) PER QQ-A-430.

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

COPPER, PER QQ-W-343 A-A-59551, TYPE S.

FINISH:

STEEL, CARBON, CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2.

BRASS, OXIDE OR BLACK FINISH PER MIL-F-493 OR NICKEL PLATING PER AMS-QQ-N-290, CLASS 1, FULLY BRIGHT, GRADE G.

ALUMINUM ALLOY, COMPOSITION 2117-T4, ANODIZED PER MIL-A-8625 OR GIVEN A CHEMICAL FILM PER MIL-DTL-5541.

IT IS NOT NECESSARY TO ANODIZE COMPOSITION 5056-H32 ALUMINUM RIVETS.

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS16536 REVISION A. PART NUMBERS REMAIN MS16536.

THIRD ANGLE PROJECTION		CUSTODIAN		REVISION	
		NATIONAL AEROSPACE STANDARDS COMMITTEE		1	
PROCUREMENT SPECIFICATION	FF-R-556	TITLE		CLASSIFICATION PART STANDARD	
		RIVET, TUBULAR, 150° FLAT COUNTERSUNK HEAD		NASM16536 SHEET 1 OF 3	



NAS Documents

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CODE:

THE PART NUMBER CONSISTS OF THE MS NUMBER, PLUS THE DASH NUMBER, PLUS THE CODE LETTER, WHEN APPLICABLE.

CODE LETTERS:

ADD "N" AS 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:

MS16536-1 = RIVET, CARBON STEEL
MS16536-16 = RIVET, BRASS, OXIDE OR BLACK CHEMICAL FINISH
MS16536-16N = RIVET, BRASS, NICKEL PLATE FINISH
MS16536-31 = RIVET, ALUMINUM ALLOY, COMPOSITION NO. 2117-T4
MS16536A31 = RIVET, ALUMINUM ALLOY, COMPOSITION NO. 5056-H32

NOTES:

- /1/ FOR REFERENCE ONLY. OPTIMUM VALUES VARY WITH CHARACTERISTICS OF MATERIAL TO BE RIVETED, AND SHOULD BE DETERMINED BY ACTUAL TEST IF POSSIBLE.
- (2) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (3) DOUBLE 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 RIVETS	49 KSI MIN.
COPPER RIVETS	24 KSI MIN.
- (4) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (5) TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMALS $\pm .005$.
- (7) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (8) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (9) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.