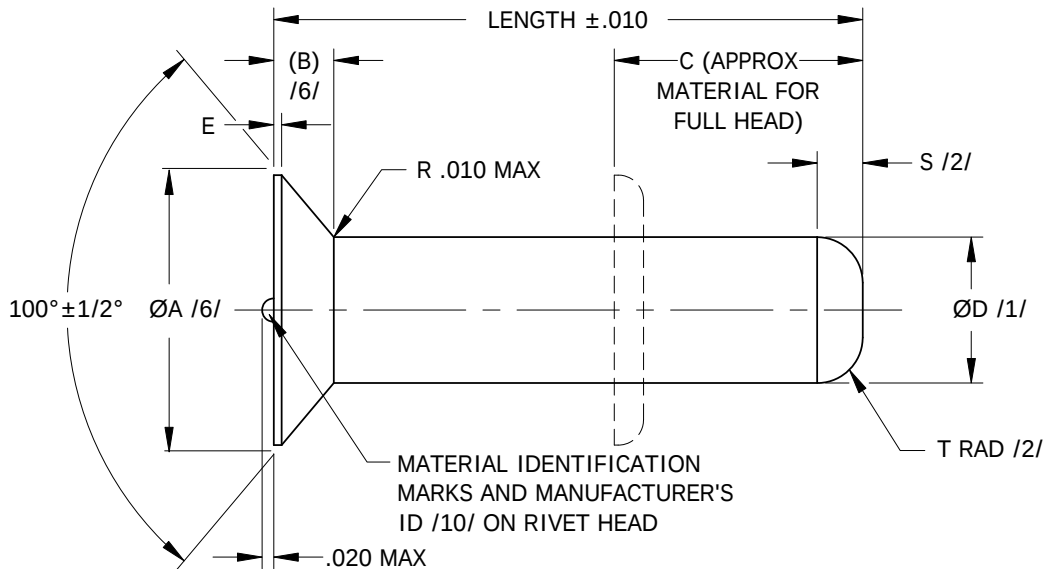
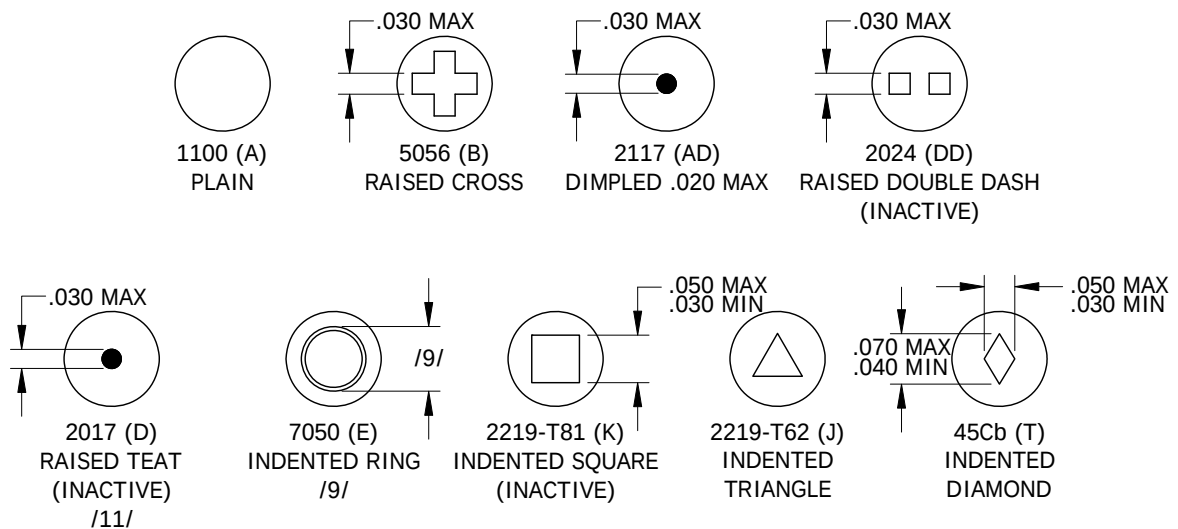


FED. SUPPLY CLASS

5320



MATERIAL IDENTIFICATION MARKS



3 COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS20426, REVISION L. PART NUMBERS REMAIN MS20426.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 3
PROCUREMENT SPECIFICATION NASM5674	TITLE RIVET, SOLID, COUNTERSUNK 100°, PRECISION HEAD, ALUMINUM AND TITANIUM COLUMBIUM ALLOY	CLASSIFICATION PART STANDARD NASM20426

TABLE I – RIVET DIMENSIONS

ØA ±.004	(B)	C	ØD +.003 -.001	E	S	T RAD
.114	.022	.094	.062 (1/16)	.004	.016	.019
.179	.036	.141	.094 (3/32)	±.002	.023	.029
.225	.042	.188	.125 (1/8)	.005	.031	.039
.286	.055	.234	.156 (5/32)	±.002	.039	.049
.353	.070	.281	.187 (3/16)	.006	.047	.059
.415	.083	.328	.219 (7/32)	±.003	.054	.069
.476	.095	.375	.250 (1/4)	.008 ±.003	.062	.078
.564	.106	.469	.312 (5/16)	.010	.078	.098
.694	.134	.562	.375 (3/8)	±.004	.094	.117

MATERIAL:

ALUMINUM 1100-F (UNS A91100) AND ALUMINUM ALLOYS 2017-T4 (UNS A92017), 2024-T4 (UNS A92024), 2117-T4 (UNS A92117), 2219-T62 (UNS A92219), 2219-T81 (UNS A922119), 5056-H32 (UNS A95056), 7050-T73 (UNS A97050) PER QQ-A-430 AND TITANIUM COLUMBIUM ALLOY 45Cb (UNS R58450) PER AMS4982.

EXAMPLE OF PART NUMBER:

MS20426 AD 4 - 12 A -5 = ALUMINUM ALLOY 2117-T4 RIVET, 1/8 DIA. (3/4 + 1/32) LONG, ANODIZE CLEAR.

INDICATES ADDITIONAL 1/32 INCH INCREMENT IN LENGTH.

NO CODE INDICATES CHEMICAL SURFACE TREATMENT PER MIL-DTL-5541, CLASS 1A, GOLD/YELLOW.

"A" INDICATES ANODIZE PER MIL-A-8625, TYPE II, CLASS 1, CLEAR.

"D" INDICATES ANODIZE PER MIL-A-8625, TYPE II, CLASS 1, DICHROMATE SEAL.

"F" INDICATES OPTION OF ANY FINISH EXCEPT AS NOTED BELOW.

"S" INDICATES CHEMICAL SURFACE TREATMENT PER MIL-DTL-5541, CLASS 1A, CLEAR.

"N" INDICATES ANODIZE PER MIL-A-8625, TYPE II, CLASS 2.

NOTE: FOR 1100 AL. CHEMICAL SURFACE TREATMENT PER MIL-DTL-5541, CLASS 1A, GOLD/YELLOW (NO CODE).

FOR 2024 AL. ANODIZE PER MIL-A-8625, TYPE II, CLASS 1, DICHROMATE SEAL OR CLEAR OR CLASS 2 WITH SPECIFIED COLOR (A, D, OR N CODE).

FOR 2017, 2117, 2219, 5056 AND 7050 AL. CHEMICAL FINISH SURFACE TREATMENT PER MIL-DTL-5541, CLASS 1A, CLEAR OR GOLD/YELLOW (CLEAR FILM SHALL BE USED ONLY WHEN AUTHORIZED) OR ANODIZE PER MIL-A-8625, TYPE II, CLASS 1 (CLEAR OR DICHROMATE SEAL) OR CLASS 2.

FOR TITANIUM COLUMBIUM, NO FINISH REQUIRED.

INDICATES LENGTH IN 1/16 OF AN INCH.

INDICATES DIAMETER IN 1/32 OF AN INCH.

"A" INDICATES 1100-F ALUMINUM

"AD" INDICATES 2117-T4 AL. ALLOY

"B" INDICATES 5056-H32 AL. ALLOY

"D" INDICATES 2017-T4 AL. ALLOY – (INACTIVE FOR NEW DESIGN)

"DD" INDICATES 2024-T4 AL. ALLOY – (INACTIVE FOR NEW DESIGN)

"K" INDICATES 2219-T81 AL. ALLOY – (INACTIVE FOR NEW DESIGN)

"E" INDICATES 7050-T73 AL. ALLOY

"T" INDICATES TITANIUM COLUMBIUM ALLOY 45Cb

"J" INDICATES 2219-T62 AL. ALLOY

BASIC MS NUMBER

REVISION

3

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MS20426

SHEET 2

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NOTES:

- /1/ .001 INCH SHANK DIAMETER INCREASE PERMISSIBLE WITHIN .100 INCH OF BASE OF HEAD.
- /2/ RIVETS MAY BE FURNISHED WITH PLAIN ENDS, OR CHAMFERED ENDS WITH A RADIUS TO THE "T" DIMENSION OR A 20° CHAMFER TO THE "S" DIMENSION.
- /3/ A PROFILE VIEW OF LAND AREA MAY VARY FROM A LINE PARALLEL WITH THE SHANK TO A CURVE THAT WILL FALL WITHIN THE LIMITS ALLOWED.
- /4/ THE CONICAL SURFACE OF THE HEAD SHALL BE CONCENTRIC WITH THE SHANK OF THE RIVET WITHIN .005 (.010 FIM).
- /5/ HEAD-COCKING ANGLE RELATIVE TO AXIS OF RIVET 1/2° MAX.
- /6/ MAXIMUM HEAD DIAMETERS ARE TO THEORETICAL SHARP CORNERS AS MEASURED BY PROJECTION.
- (7) FOR PART NUMBERS OF RIVET LENGTH NOT LISTED SHOW 1/16 INCREMENT REQUIRED.
- (8) ADDITIONAL 1/32 LENGTH INCREMENTS MAY BE OBTAINED BY ADDING -5 AFTER THE LAST DIGIT OR LETTER IN PART NUMBER.
- /9/ OUTER DIAMETER OF INDENTED RING (7050 RIVETS) SHALL BE A MAXIMUM OF 75% OF RIVET SHANK DIAMETER. THE MAXIMUM DEPTH OF THE RING SHALL BE .010 INCH. INDENTED RING IS REQUIRED ON 7050 RIVETS MANUFACTURED AFTER 2 JULY 1990.
- /10/ MANUFACTURER'S IDENTIFICATION IS REQUIRED TO BE DEPRESSED ON RIVET HEADS WITH A SHANK DIAMETER .125 INCH AND LARGER MANUFACTURED AFTER 2 JULY 1990.
- /11/ ALUMINUM ALLOY 2017-T4 RIVETS WITH 33 KSI MIN. UNDRIVEN SHEAR STRENGTHS ARE ACCEPTABLE UNTIL 2 JULY 1990.
- (12) DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (13) UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS ±.010.
- (14) INTERCHANGEABILITY RELATION WITH AN426 RIVETS: MS20426 RIVETS OF LIKE DASH NUMBERS ARE UNIVERSALLY, FUNCTIONALLY, AND DIMENSIONABLY INTERCHANGEABLE.
- (15) IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
- (16) 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.
- (17) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (18) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION

3

③ COMPLETELY REVISED

NAS 20426

SHEET 3



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