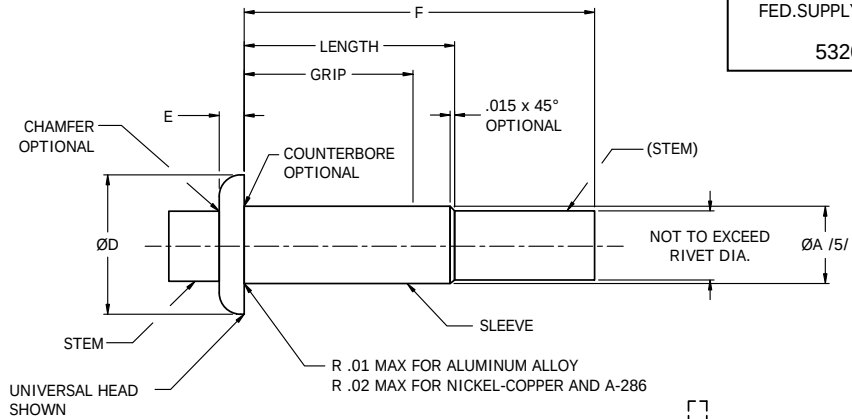


BRAZIER HEAD
ALTERNATE DESIGN
BRAZIER HEAD INACTIVE FOR
DESIGN AFTER NOVEMBER 1958
PROCURE UNIVERSAL HEAD ONLY /9/

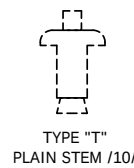


FED.SUPPLY CLASS

5320



TYPE "E"
CHEMICALLY EXPANDED /6/



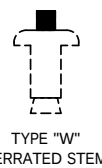
TYPE "T"
PLAIN STEM /10/



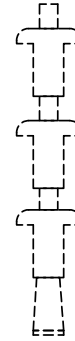
TYPE "H"
DRIVE PIN /8/



TYPE "K"
KNOB STEM /7/



TYPE "W"
SERRATED STEM



TYPE "C"
MANDREL LOADED

RIVET IDENTIFICATION CODE

TABLE I – MATERIAL, FINISH, AND LUBRICATION

COMPONENT	MATERIAL	FINISH AND LUBRICATION
SLEEVE	CARBON STEEL, C1008 (UNS G10080), C1012 (UNS G10120), C1018 (UNS G10180) PER ASTM A510/A510M	CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2
STEM	CARBON STEEL PER ASTM A510/A510M	CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2
SLEEVE	A286 CRES (UNS S66286) PER AMS5731	PASSIVATE PER AMS2700, METHOD 1, CLASS 4 & LUBRICATE PER AS5272, TYPE I
STEM	305 CRES (UNS S30500) PER ASTM A493	PASSIVATE PER AMS2700, METHOD 1, CLASS 4
SLEEVE	A286 CRES (UNS S66286) PER AMS5731	CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2
STEM	305 CRES (UNS S30500) PER ASTM A493	PASSIVATE PER AMS2700, METHOD 1, CLASS 4
SLEEVE	5056 ALUMINUM ALLOY (UNS 95056) PER QQ-A-430	ANODIZE PER MIL-A-8625 TYPE II, CLASS 1 OR CHEMICAL SURFACE TREATMENT PER MIL-DTL-5541, CLASS 1A
STEM	CARBON STEEL PER ASTM A510/A510M	AS REQUIRED FOR CORROSION PROTECTION
SLEEVE	2117 ALUMINUM ALLOY (UNS 92117) PER QQ-A-430	ANODIZE PER MIL-A-8625 TYPE I, CLASS 1 OR CHEMICAL SURFACE TREATMENT PER MIL-DTL-5541, CLASS 1A
STEM	CARBON STEEL PER ASTM A510/A510M	AS REQUIRED FOR CORROSION PROTECTION
SLEEVE	NICKEL-COPPER PER QQ-N-281, CLASS A	CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2
STEM	CARBON STEEL PER ASTM A510/A510M	AS REQUIRED FOR CORROSION PROTECTION /13/
SLEEVE	NICKEL-COPPER PER QQ-N-281, CLASS A	SILVER PLATE PER ASTM B700
STEM	CARBON STEEL PER ASTM A510/A510M	AS REQUIRED FOR CORROSION PROTECTION
SLEEVE	NICKEL-COPPER PER QQ-N-281, CLASS A	WWM CARBO WAX
STEM	CARBON STEEL PER ASTM A510/A510M	AS REQUIRED FOR CORROSION PROTECTION
SLEEVE	NICKEL-COPPER PER QQ-N-281, CLASS A	DRY FILM LUBE PER AS5272, TYPE I
STEM	CARBON STEEL PER ASTM A510/A510M	AS REQUIRED FOR CORROSION PROTECTION

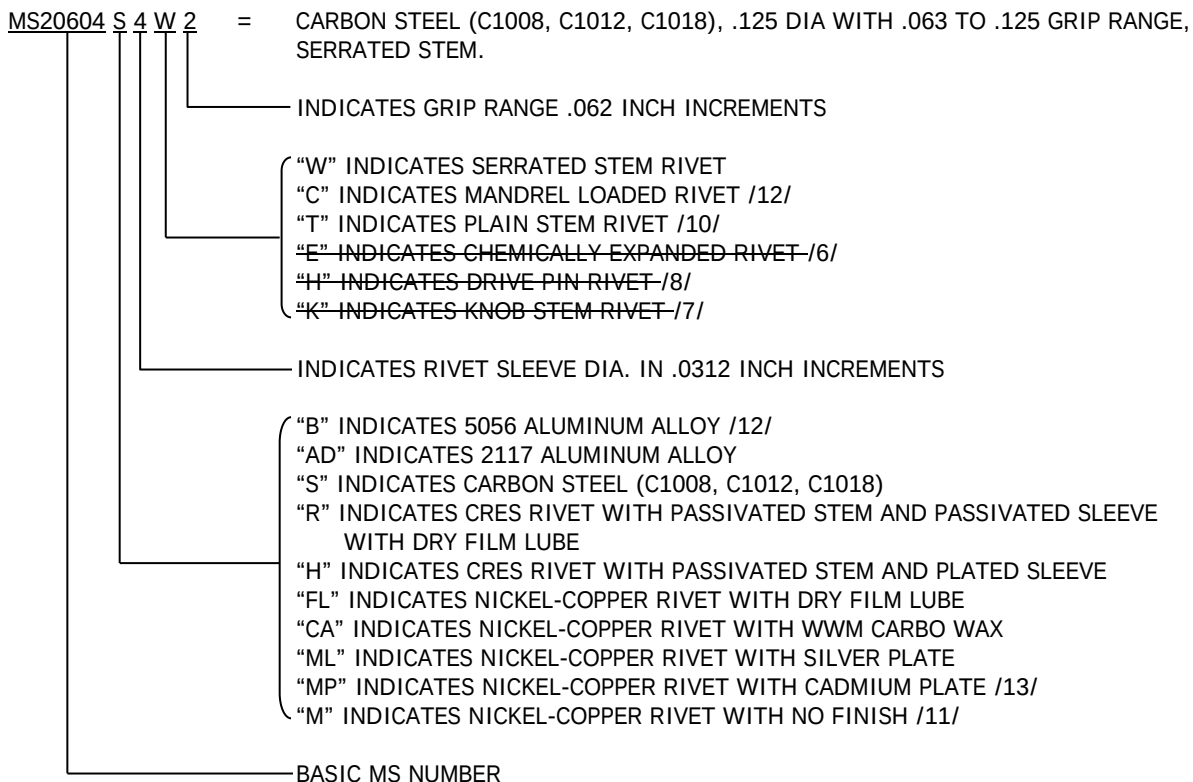
THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS20604, REVISION K. PART NUMBERS REMAIN MS20604.

THIRD ANGLE PROJECTION	
PROCUREMENT SPECIFICATION	
NASM8814	

CUSTODIAN	REVISION
NATIONAL AEROSPACE STANDARDS COMMITTEE	3
TITLE	CLASSIFICATION PART STANDARD
RIVET, BLIND, NON-STRUCTURAL, UNIVERSAL HEAD, CLASS 1	NASM20604

SHEET 1 OF 10

EXAMPLE OF PART NUMBER:



NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (2) FOR LIMITATIONS FOR DESIGN USAGE, USE STANDARD NASM33557.
- (3) FOR STRUCTURAL BLIND RIVETS, USE STANDARDS NASM20600, NASM20601.
- (4) COLOR: 5056 ALUMINUM ALLOY RIVETS SHALL BE SUITABLY IDENTIFIED BY AN ORANGE COLOR SIMILAR TO FED-STD-595, COLOR NO. 32246.
- /5/ .001 SHANK DIAMETER INCREASE PERMISSIBLE WITHIN .100 INCH OF BASE OF HEAD.
- /6/ CHEMICALLY EXPANDED RIVETS (TYPE “E”) CANCELLED AFTER 1 MARCH 1983. NO SUPERSEDING DOCUMENT.
- /7/ KNOB STEM RIVETS (TYPE “K”) CANCELLED AFTER MARCH 3, 1969. USE SERRATED STEM (TYPE “W”).
- /8/ DRIVE PIN RIVETS (TYPE “H”) CANCELLED AFTER MARCH 3, 1969. USE NASM24662.
- /9/ BRAZIER HEAD CANCELLED AFTER MARCH 3, 1969. USE UNIVERSAL HEAD.
- /10/ PLAIN STEM RIVETS (TYPE “T”) ARE INACTIVE FOR NEW DESIGN AFTER NOVEMBER 1, 1986. USE SERRATED STEM (TYPE “W”).

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SHEET 2



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- /11/ NICKEL-COPPER RIVETS WITH NO FINISH ARE INACTIVE FOR NEW DESIGN AFTER MARCH 3, 1969.
- /12/ MANDREL LOADED ALUMINUM ALLOY 5056 RIVETS INACTIVE FOR NEW DESIGN AFTER MARCH 3, 1969.
- /13/ CADMIUM PLATED NICKEL-COPPER RIVETS ARE INACTIVE FOR DESIGN AFTER JULY 24, 1969.
- (14) INTERCHANGEABILITY RELATIONSHIP. MS20604 RIVETS CAN REPLACE THE CANCELLED MS20606 RIVETS IDENTIFIED BY THE SAME DASH NUMBERS. THE CANCELLED MS20606 PARTS CANNOT REPLACE THE MS20604 RIVETS AND SHOULD BE USED UNTIL EXISTING STOCK IS DEPLETED. USE ONLY THE SUPERSEDING MS PARTS OF THE SAME DASH NUMBERS FOR DESIGN AND REPLACEMENT.
- (15) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (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) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (18) 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 (19) FOR DESCRIPTION OF STATUS NOTES SEE NAS380.

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SHEET 3



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