

FED. SUPPLY CLASS

5320

1. SCOPE

- 1.1 Scope. This specification covers drive pin type blind rivets which can be installed in assemblies or construction where access to only one side is available (see 6.1).
- 1.2 Classification
- 1.2.1 Types and grades. Rivets covered by this specification shall be of the following types and grades, as specified in the invitation for bids (see 6.2).

Type I – Universal head
Grade A – Aluminum-alloy bodies
Grade B – Steel bodies

Type II – Countersunk head
Grade A – Aluminum-alloy bodies
Grade B – Steel bodies

2. APPLICABLE DOCUMENTS

- 2.1 The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of the specification to the extent specified herein.

Federal

QQ-A-430 Aluminum Alloy Rod and Wire; for Rivets and Cold Heading
~~FED-STD-66 Steel: Chemical Composition and Hardenability~~

Copies can be obtained from the Department of Defense Single Stock Point (DODSSP). <http://dodssp.daps.dla.mil>.

Military

MIL-DTL-5541 Chemical Films and Chemical Film Materials for Aluminum and Aluminum Alloys
MIL-A-8625 Anodic Coatings, for Aluminum and Aluminum Alloys
MIL-STD-2073/1 Standard Practice for Military Packaging

Copies can be obtained from the Department of Defense Single Stock Point (DODSSP).
<http://dodssp.daps.dla.mil>.

American Society for Quality (ASQ)

ANSI/ASQ Z1.4 Sampling Procedures and Tables for Inspection by Attributes

Copies can be obtained from the American Society for Quality, 600 North Plankinton Ave., Milwaukee, WI 53203.
www.asq.org

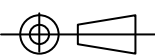
ASTM International

ASTM E1282 Standard Guide for Specifying the Chemical Compositions and Selecting Sampling Practices and Quantitative Analysis Methods for Metals, Ores, and Related Materials
ASTM E172 Standard Practice for Describing and Specifying the Excitation Source in Emission Spectrochemical Analysis
ASTM D3951 Standard Practice for Commercial Packaging

Copies can be obtained from ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959. www.astm.org (1) COMPLETELY REVISED

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THIRD
ANGLE
PROJECTION



CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

1

PROCUREMENT
SPECIFICATION

TITLE

RIVET, BLIND, DRIVE TYPE

NONE

CLASSIFICATION
SPECIFICATION

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Document Sharing Hub

Aerospace Industries Association of America (AIA/NAS)

NASM1312 Fasteners, Test Methods
NASM24661 Rivet, Blind, Countersunk Head, Drive Type
NASM24662 Rivet, Blind, Universal Head, Drive Type

Copies can be obtained from the Aerospace Industries Association, 1000 Wilson Blvd., Suite 1700, Arlington, VA 22209. www.aia-aerospace.org

SAE International

AIR4127 Steel: Chemical Composition and Hardenability
AMS2770 Heat Treatment of Aluminum Alloys
AMS2700 Passivation Treatments for Austenitic, Ferritic and Martensitic CRES (Fastening Devices)
AMS-QQ-P-416 Plating, Cadmium (Electrodeposited)

Copies can be obtained from SAE International, 400 Commonwealth Dr., Warrendale, PA 15096-0001. www.sae.org

(Copies of specifications, standards, drawings, and publications required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

3. REQUIREMENTS

3.1 Materials

3.1.1 Rivet bodies. Grade A rivet bodies shall be made of aluminum-alloy wire conforming to QQ-A-430, Composition 2117-T4 or Composition 5056-H32 (see 6.2). Grade B rivet bodies shall be made from carbon steel wire conforming to the requirements of ~~FED-STD-66~~ AIR4127, AISI Numbers C1006 thru C1041 (see 6.2).

3.1.2 Drive pins. Drive pins for Grade A, Composition 2117-T4 rivet bodies, shall conform to ~~FED-STD-66~~ AIR4127, CRES 300 series; for Grade A, Composition 5056-H32 rivet bodies shall conform to ~~FED-STD-66~~ AIR4127, CRES 305 only. Drive pins for Grade B rivet bodies shall conform to ~~FED-STD-66~~ AIR4127, CRES 300 series or carbon steel.

3.2 Protective finish

3.2.1 Unless otherwise specified in the invitations for bid, contract or order (see 6.2), rivet bodies and drive pins shall be plated, coated or treated in accordance with 3.2.2 through 3.2.4.

3.2.2 Anodizing or chemical treatment. Grade A rivet bodies, Composition 2117-T4 aluminum alloy, shall be anodized in accordance with MIL-A-8625 or chemically surface treated in accordance with MIL-DTL-5541. Anodizing of Composition 5056-H32 aluminum alloy rivet bodies is not necessary.

3.2.3 Cadmium plating. Carbon steel pins and Grade B rivet bodies shall be cadmium plated. Cadmium plating shall conform to the requirements of AMS-QQ-P-416, Type II, Class 2.

3.2.4 Passivation. The CRES drive pins shall be passivated in accordance with AMS2700, Method 1, Class 4.

3.3 Heat treatment

3.3.1 Grade A (aluminum alloy) rivets. Heat treatment of 2117-T4 rivets shall conform to AMS2770; Composition 5056-H32 rivets shall conform to the requirements of QQ-A-430.

3.3.2 Grade B (steel) rivets. The hardness of Grade B rivet bodies shall not exceed 95 HRB.

3.4 Design and dimensions. Design, dimensions and tolerances shall be in accordance with NASM24661 or NASM24662, as applicable. Rivets shall conform to dimensions and tolerances after application of protective finish.

3.5 Identification

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