

FED. SUPPLY CLASS

5320

1. SCOPE

THIS DOCUMENT HAS BEEN PROMULGATED TO LIMIT THE SELECTION OF NON-STRUCTURAL RIVETS IN ENGINEERING AND DESIGN.

2. NOTES

2.1. USE OF NON-STRUCTURAL RIVETS FOR BLIND ATTACHMENT SHALL BE SUBJECT TO THE FOLLOWING LIMITATIONS:

2.1.1. FOR NON-STRUCTURAL USE ON AIRCRAFT AND GROUND EQUIPMENT.

2.1.2. NOT FOR USE IN APPLICATIONS WHERE FAILURE OF THE RIVET WOULD ENDANGER SAFETY OF PERSONNEL OR CAUSE MALFUNCTIONING OF EQUIPMENT OR AIRCRAFT.

2.1.3. THEY MAY BE USED IN APPLICATIONS SUCH AS:

- (a) FASTENING NAME, WARNING, AND INSTRUCTION PLATES.
- (b) ASSEMBLY OF NONSTRUCTURAL COMPONENTS.
- (c) SECURING PLATE NUTS WHEN IT IS EVIDENT THAT RIVETS POSSESS ADEQUATE STRENGTH TO WITHSTAND SPECIFIED NUT PUSH OUT AND TORQUE OUT LOADS.

TABLE I – RECOMMENDED USE

RIVET DIAMETER	HOLE LIMITS
.094	.097-.101
.125	.129-.132
.156	.160-.164
.188	.192-.196
.250	.256-.260

2.2. WHEN MILLING OF COUNTERSUNK RIVETS IS REQUIRED TO OBTAIN FLUSHNESS, THE RIVET HEADS SHALL NOT PROTRUDE MORE THAN .005 ABOVE THE SURROUNDING SHEET PRIOR TO MILLING.

2.3. WHEN DRIVE PIN-TYPE NON-STRUCTURAL RIVETS ARE UTILIZED, SUFFICIENT SUPPORT MUST EXIST TO WITHSTAND THE FORCES NECESSARY TO DRIVE THE PINS.

2.4. CADMIUM PLATED, NICKEL-COPPER ALLOY RIVETS SHALL NOT BE USED IN APPLICATIONS WHERE THE AMBIENT TEMPERATURE IS ABOVE 400 °F.

2.5. STRUCTURAL RIVETS MAY BE USED FOR REPLACEMENT.

2.6. DIMENSIONS ARE IN INCHES.

THIS IS A DESIGN STANDARD NOT TO BE USED AS A PART NUMBER.

② COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS33557, REVISION A.



CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

2

PROCUREMENT
SPECIFICATION

NONE

TITLE

**NONSTRUCTURAL RIVETS FOR BLIND ATTACHMENT;
LIMITATIONS FOR DESIGN AND USAGE**

CLASSIFICATION
DESIGN STANDARD

MS33557

SHEET 1 OF 1

