

FED. SUPPLY CLASS

5320

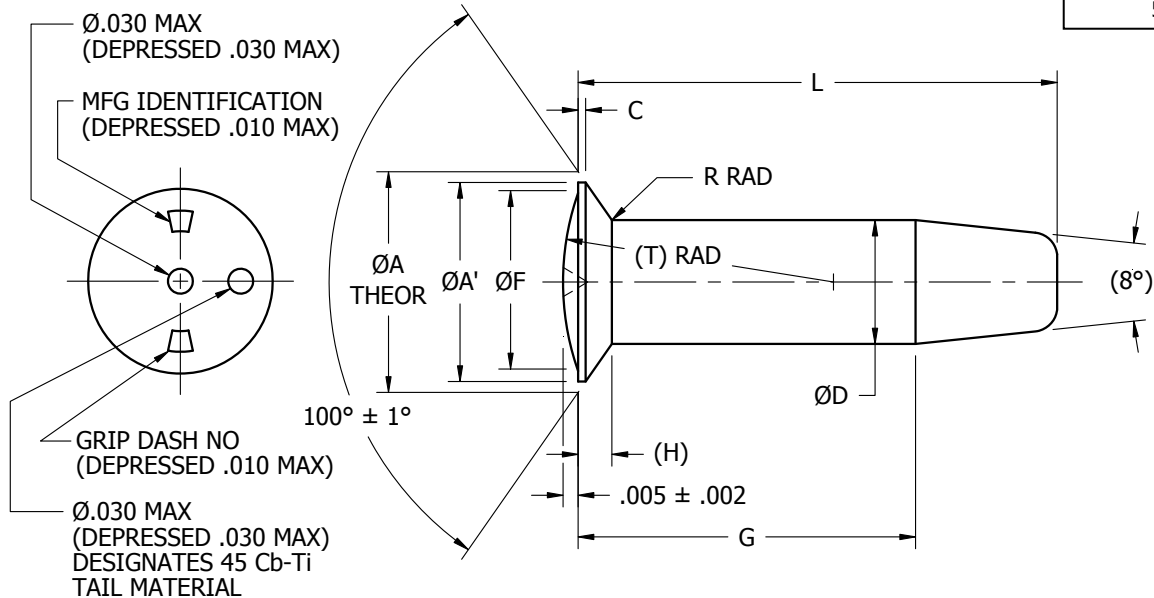


TABLE I – DIMENSIONS

FIRST DASH NO. DIA	NOM DIA	ØD +.0000 -.0005	ØA ±.0025	ØA' MIN	C ±.002	ØF ±.005	(H)	R RAD ±.005	(T) RAD	G GRIP	L LENGTH	WEIGHT
5	5/32	.1635	.286	.271	.004	.261	.051	.020	1.70	SEE TABLE II		SEE TABLE III
6	3/16	.1895	.353	.336	.005	.326	.069	.025	2.66			
8	1/4	.2495	.476	.456	.006	.446	.095	.025	4.98			
10	5/16	.3120	.564	.540	.008	.530	.106	.035	7.03			
12	3/8	.3745	.694	.670	.008	.660	.134	.035	10.90			

MATERIAL:

BODY: 6Al-4V (UNS R56400) TITANIUM ALLOY PER AMS4967.
TAIL: 45Cb (UNS R58450) TITANIUM ALLOY PER AMS4982.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-81200 OR AMS2801.

BODY: HEAT TREATED TO 95 KSI MINIMUM SHEAR STRENGTH.

TAIL: HEAT TREATED TO 50 KSI MINIMUM SHEAR STRENGTH.

FINISH:

NONE.

① COMPLETELY REVISED

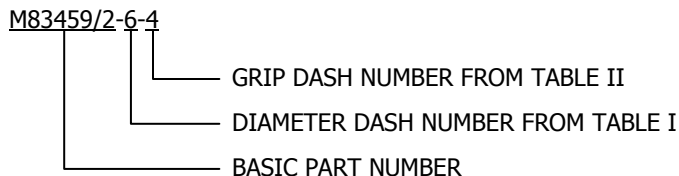
THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-R-83459/2 REVISION B. PART NUMBERS REMAIN M83459/2.

THIRD ANGLE PROJECTION		CUSTODIAN	REVISION
		NATIONAL AEROSPACE STANDARDS COMMITTEE	1
		TITLE	CLASSIFICATION PART STANDARD
PROCUREMENT SPECIFICATION		RIVET, TITANIUM, BIMETAL, 95 KSI Fsu, 100° TENSION CROWN HEAD, TYPE II	NASM83459-2
NASM83459			SHEET 1 OF 3

LUBRICATION:

AS SPECIFIED IN NASM83459, CETYL ALCOHOL IN ACCORDANCE WITH ~~MIL-L-87132~~ AS87132, TYPE I, GRADE B.

EXAMPLE OF PART NUMBER:



NOTES:

- (1) DO NOT USE RIVETS WHICH MUST BE CUT TO LENGTH.
- (2) DO NOT USE RIVETS IN LESS THAN SPECIFIC MINIMUM GRIP.
- (3) SURFACE ROUGHNESS: STRAIGHT SHANK, HEAD TO SHANK RADIUS AND BEARING SURFACE OF HEAD: 63 MICROINCHES Ra; ALL OTHER SURFACES: 125 MICROINCHES Ra PER ASME B46.1.
- (4) CONCENTRICITY: CONICAL SURFACE OF HEAD TO "ØD" WITHIN .003 FIM.
- (5) DIMENSIONS IN INCHES AND APPLY PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (6) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (7) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (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.

① COMPLETELY REVISED

REVISION
1
NASM83459/2
SHEET 2

