

INCH-POUND

MIL-DTL-7885/6D

29 July 1997

SUPERSEDING

MIL-R-7885/6C

18 April 1988

DETAIL SPECIFICATION SHEET

RIVETS, BLIND, STRUCTURAL, UNIVERSAL PROTRUDING HEAD, 5056 AL ALLOY SLEEVE, MECHANICALLY LOCKED ALLOY STEEL SPINDLE OVERSIZE DIAMETER (TYPE I, STYLE B, CLASS 1)

This specification is approved for use by all Departments and Agencies of the Department of Defense.

The complete requirements for acquiring the blind rivets described herein shall consist of this document and the latest issue of MIL-R-7885.

DESIGN AND USAGE LIMITATION. Rivets shall be used in compliance with the limitations of MS33522.

INSTALLATION. Rivets shall be capable of being installed by a tool conforming to MIL-R-85188. Lubricant shall not be removed prior to installation.

REQUIREMENTS:

MATERIAL:

Sleeve: 5056 Al Alloy per QQ-A-430 (UNS A95056).

Spindle: 8740 steel per AMS6322 (UNS G87400).

Locking Feature: A-286 CRES per AMS 5731 (UNS S66286) or 5056 Al Alloy per QQ-A-430 (UNS A95056).

Lubricant: See general specification (MIL-R-7885).

Grip Adjusting Feature (Optional): 10XX series carbon steel, 8740 steel per AMS 6322 (UNS G87400), OR 7050-T73 AL Alloy per QQA-430 (UNS A97050)

PROTECTIVE TREATMENT:

5056 Al Alloy: Chemically treated per MIL-C-5541, color clear.

8740 Alloy Steel: Cadmium plated per QQ-P-416, Type II, Class 2.

10XX Series Carbon Steel: Cadmium plated per QQ-P-416, Type I or II, Class 2.

A-286 CRES: Parts manufactured after August 1988 shall be passivated per QQ-P-35.

7050-T73 AL Alloy: Chemically treated per MIL-C-5541.

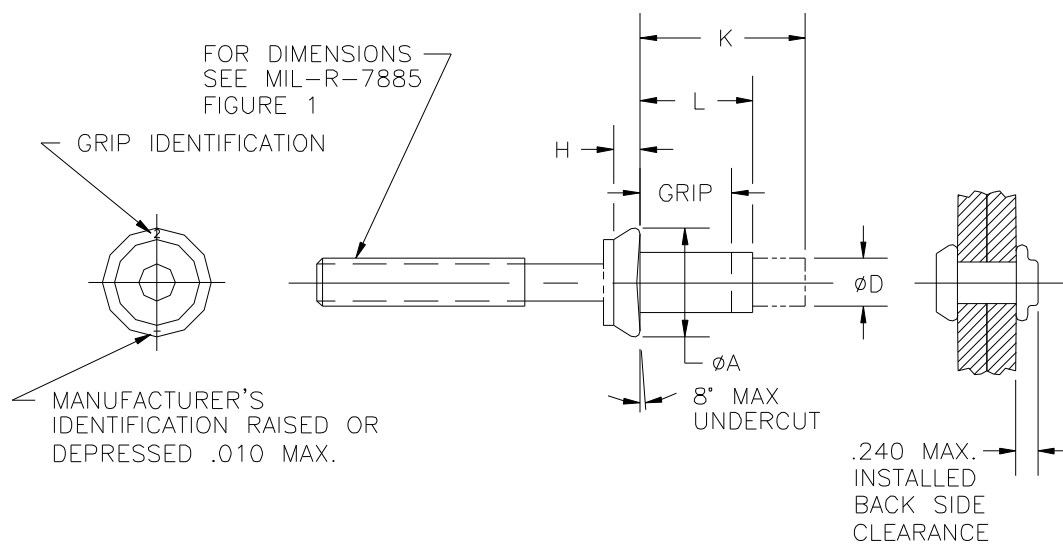
SURFACE TEXTURE: Surface texture shall be measured per ANSI/ASME B46.1 and shall not exceed 125 microinches.

TOLERANCES: Unless otherwise specified, decimals +/- .010, angles +/- 2°.

Unless otherwise specified, dimensions are in inches.

Break all sharp edges and remove all burrs and slivers.

MIL-DTL-7885/6D



Optional Driving Anvil Gold Colored to Identify Style "A" Rivets

TABLE I

| Nominal Size | Basic Body Dia | ØA | | ØD | | H | | Installation hole Limits | |
|--------------|----------------|------|------|------|------|------|------|--------------------------|------|
| | | Max | Min | Max | Min | Max | Min | Max | Min |
| 4 | .125 | .260 | .240 | .143 | .139 | .064 | .054 | .146 | .143 |
| 5 | .156 | .322 | .302 | .176 | .172 | .077 | .067 | .180 | .176 |
| 6 | .187 | .385 | .365 | .204 | .200 | .090 | .080 | .209 | .205 |

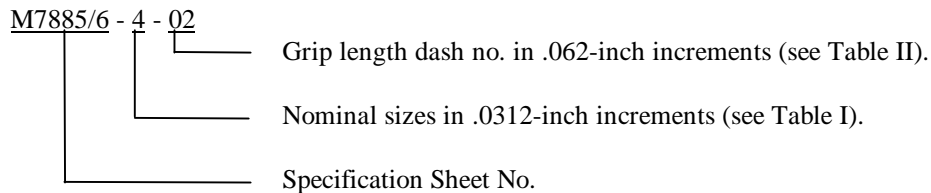
MIL-DTL-7885/6D

TABLE II

| Grip Limits | | Nominal Sizes | | | | | | | | |
|-------------|------|---------------|---------------------|----------|----------|---------------------|----------|----------|---------------------|----------|
| | | 4 | | | 5 | | | 6 | | |
| | | Dash No. | L +.000 -.030 | K Max | Dash No. | L +.000 -.030 | K Max | Dash No. | L +.000 -.030 | K Max |
| Min | Max | | | | | | | | | |
| (a) | .062 | -01 | .175 | .370 | -01 | .203 | .430 | -01 | .242 | .450 |
| .063 | .125 | -02 | .238 | .460 | -02 | .246 | .470 | -02 | .265 | .500 |
| .126 | .187 | -03 | .301 | .520 | -03 | .309 | .530 | -03 | .328 | .550 |
| .188 | .250 | -04 | .363 | .580 | -04 | .371 | .600 | -04 | .390 | .620 |
| .251 | .312 | -05 | .426 | .650 | -05 | .434 | .660 | -05 | .453 | .680 |
| .313 | .375 | -06 | .488 | .710 | -06 | .496 | .720 | -06 | .515 | .740 |
| .376 | .437 | -07 | .551 | .780 | -07 | .559 | .790 | -07 | .578 | .820 |
| .438 | .500 | -08 | .613 | .840 | -08 | .621 | .850 | -08 | .640 | .890 |
| .501 | .562 | -09 | .676 | .900 | -09 | .684 | .910 | -09 | .703 | .950 |
| .563 | .625 | | | | -10 | .746 | .980 | -10 | .765 | 1.010 |
| .626 | .687 | | | | -11 | .809 | 1.040 | -11 | .828 | 1.070 |
| .688 | .750 | | | | | | | -12 | .890 | 1.140 |

- (a) Do not use part number M7885/6-4-01 below .025 grip.
 Do not use part number M7885/6-5-01 below .031 grip.
 Do not use part number M7885/6-6-01 below .037 grip

EXAMPLE OF PART NUMBER:



Changes from previous issue: Marginal notations are not used in this revision to identify changes with respect to the previous issue due to extent of changes.

Custodians:
 Army - AR
 Navy - AS
 Air Force - 99

Preparing Activity:
 DLA-IS
 (Project No. 5320-0901-06)

Review Activities:
 Army - AV
 Navy - MC
 Air Force - 82