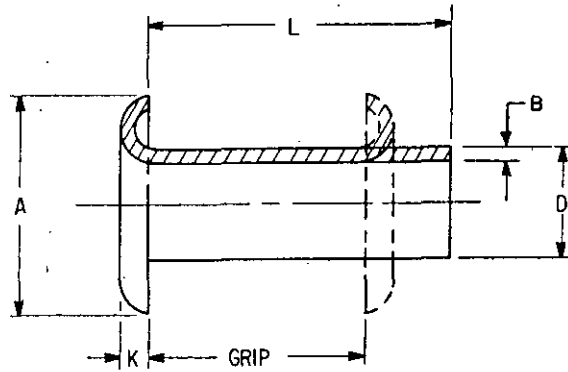
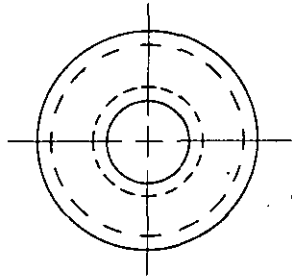
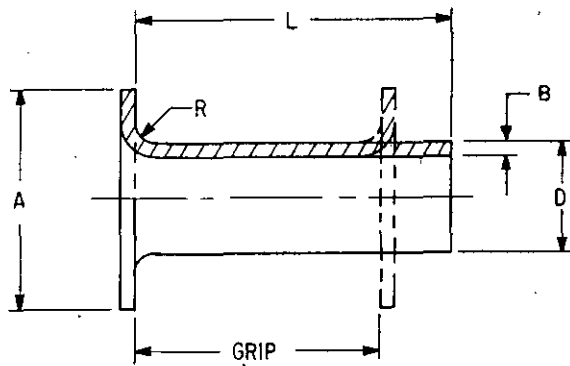
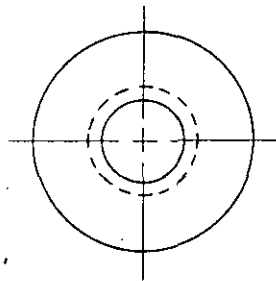


FED. SUP CLASS
5320User activities:
ARMY-AT, ME
NAVY-MC,Review activities:
ARMY-GL, M
NAVY-ASDLA-IS
NSA-NS

ROUND TYPE HEAD



FLAT TYPE HEAD

This military standard is approved for use by all Departments
B. Agencies of the Department of Defense. Selection for all new
engineering and design applications and for repetitive use shall
be made from this document when applicable.

P.A. AR	TITLE RIVET, TUBULAR, ROUND AND FLAT TYPE HEAD, METRIC	MILITARY STANDARD	
Other Cust 99		DS 51403	
PROCUREMENT SPECIFICATION FF-R-556	SUPERSEDES	PAGE 1	OF 4

DD FORM 672-1 (Coordinated)
1 MAR 72

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5320-0386

APPROVED 21 AUG 81 REVISED

METRIC

User activities:
ARMY-AT, ME
NAVY-MC

Review activities:
ARMY - GL, MI
NAVY - AS
DLA - IS
NSA - NS

FED. SUP CLASS
5320

TABLE I.

DASH NUMBER	NOMINAL DIAMETER	A	A TOLERANCE	B	D DIA	$\frac{L}{K}$	K TOLERANCE	L	L TOLERANCE	R $\frac{2}{1}$ MAX	GRIP MAX
012002 012003 012004	1.20	2.00	± 0.15	0.22 0.18	1.18 1.12	0.25	± 0.05	2.00	± 0.10	0.20	1.00
								3.00	± 0.10		2.00
								4.00	± 0.15		3.00
012005 012006 012007								5.00	± 0.15		4.00
								6.00	± 0.15		5.00
								7.00	± 0.18		6.00
012008 012009 012010								8.00	± 0.18		7.00
								9.00	± 0.18		8.00
								10.00	± 0.18		9.00
016002 016003 016004	1.60	2.50	± 0.15	0.28 0.23	1.58 1.52	0.35	± 0.05	2.00	± 0.10	0.20	0.90
								3.00	± 0.10		1.90
								4.00	± 0.15		2.90
016005 016006 016007								5.00	± 0.15		3.90
								6.00	± 0.15		4.90
								7.00	± 0.18		5.90
016008 016009 016010								8.00	± 0.18		6.90
								9.00	± 0.18		7.90
								10.00	± 0.18		8.90
020002 020003 020004	2.00	3.20	± 0.20	0.33 0.27	1.98 1.92	0.40	± 0.05	2.00	± 0.10	0.20	0.70
								3.00	± 0.10		1.70
								4.00	± 0.15		2.70
020005 020006 020007								5.00	± 0.15		3.70
								6.00	± 0.15		4.70
								7.00	± 0.18		5.70
020008 020009 020010								8.00	± 0.18		6.70
								9.00	± 0.18		7.70
								10.00	± 0.18		8.70
025003 025004 025005	2.50	4.00	± 0.20	0.39 0.32	2.48 2.42	0.50	± 0.05	3.00	± 0.10	0.25	1.30
								4.00	± 0.15		2.30
								5.00	± 0.15		3.30
025006 025007 025008								6.00	± 0.15		4.30
								7.00	± 0.18		5.30
								8.00	± 0.18		6.30
025009 025010 025012								9.00	± 0.18		7.30
								10.00	± 0.18		8.30
								12.00	± 0.20		10.30
025015 025018 025020								15.00	± 0.20		13.30
								18.00	± 0.20		16.30
								20.00	± 0.23		18.30
030003 030004 030005	3.00	4.50	± 0.20	0.44 0.36	2.98 2.92	0.55	± 0.05	3.00	± 0.10	0.30	1.00
								4.00	± 0.15		2.00
								5.00	± 0.15		3.00
030006 030007 030008								6.00	± 0.15		4.00
								7.00	± 0.18		5.00
								8.00	± 0.18		6.00
030009 030010 030012								9.00	± 0.18		7.00
								10.00	± 0.18		8.00
								12.00	± 0.20		10.00
030015 030018 030020								15.00	± 0.20		13.00
								18.00	± 0.20		16.00
								20.00	± 0.23		18.00

APPROVED 21 AUG 81 REVISED

P.A. AR Other Cost 99	TITLE RIVET, TUBULAR, ROUND AND FLAT TYPE HEAD, METRIC	MILITARY STANDARD DS 51403
PROCUREMENT SPECIFICATION FF-R-556	SUPERSEDES	PAGE 2 OF 4

FED. SUP CLASS
5320

TABLE I. Continued.

DASH NO	NOM DIA	A	A TOL	B	D DIA	L/ K	X TOL	L	L TOL	R MAX	GRIP MAX
040004 040005 040006	4.00	6.00	±0.25	0.55 0.45	3.970 3.895	0.70	±0.10	4.00	±0.15	0.40	1.80
								5.00	±0.15		2.80
								6.00	±0.15		3.80
040007								7.00	±0.18		4.80
040008								8.00	±0.18		5.80
040009								9.00	±0.18		6.80
040010								10.00	±0.18		8.80
040012								12.00	±0.20		9.80
040015								15.00	±0.20		12.80
040018								18.00	±0.20		15.80
040020								20.00	±0.23		17.80
040022								22.00	±0.23		19.80
040025								25.00	±0.23		22.80
050004 050005 050006	5.00	7.50	±0.25	0.66 0.54	4.970 4.895	0.80	±0.10	4.00	±0.15	0.50	1.30
								5.00	±0.15		2.30
								6.00	±0.15		3.30
050007								7.00	±0.18		4.30
050008								8.00	±0.18		5.30
050009								9.00	±0.18		6.30
050010								10.00	±0.18		7.30
050012								12.00	±0.20		9.30
050015								15.00	±0.20		12.30
050018								18.00	±0.20		15.30
050020								20.00	±0.23		17.30
050022								22.00	±0.23		19.30
050025								25.00	±0.23		22.30
060006 060007 060008	6.00	9.00	±0.25	0.77 0.63	5.970 5.895	1.00	±0.10	6.00	±0.15	0.60	3.00
								7.00	±0.18		4.00
								8.00	±0.18		5.00
060009								9.00	±0.18		6.00
060010								10.00	±0.18		7.00
060012								12.00	±0.20		9.00
060015								15.00	±0.20		12.00
060018								18.00	±0.20		15.00
060020								20.00	±0.23		17.00
060022								22.00	±0.23		19.00
060025								25.00	±0.23		22.00
060028								28.00	±0.23		25.00
060030								30.00	±0.23		27.00

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this document, when applicable.

P. A. Other Cust. 99	International Interest	TITLE RIVET, TUBULAR, ROUND AND FLAT TYPE HEAD, METRIC	MILITARY STANDARD DS 51403
PROCUREMENT SPECIFICATION FF-R-556		SUPERSEDES:	PAGE 3 OF 4

FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5320-0186

APPROVED 21 AUG 81 REVISED

User activities:

ARMY - AT, ME
NAVY - MC

Review activities:

ARMY - GL, M1
NAVY - AS
DLA - IS
NSA - NS

User activities:

ARMY - AT, HE
NAVY - MC

Review activities:

ARMY - GL, MI
NAVY - AS
DLA - TS
NSA - RS

TABLE I. Continued.

FED. SUP CLASS
5320

DASH NO	NOM DIA	A	A TOLERANCE	B	D DIA	K 1/ K	K TOLERANCE	L	L TOLERANCE	2/ R MAX	GRIP MAX
080007 080008 080009								7.00 8.00 9.00	± 0.18 ± 0.18 ± 0.18		3.40 4.40 5.40
080010 080012 080015								10.50 12.00 15.00	± 0.18 ± 0.20 ± 0.20		6.40 8.40 11.40
080018 080020 080022	8.00	12.00	± 0.30	0.94 0.77	7.96 7.87	1.30	± 0.10	18.00 20.00 22.00	± 0.20 ± 0.23 ± 0.23	0.80	14.40 16.40 18.40
080025 080028 080030								25.00 28.00 30.00	± 0.23 ± 0.23 ± 0.23		21.40 24.40 26.40
080032 080035								32.00 35.00	± 0.25 ± 0.25		28.40 31.40
100008 100009 100010								8.00 9.00 10.00	± 0.18 ± 0.18 ± 0.18		4.30 5.30 6.30
100012 100015 100018								12.00 15.00 18.00	± 0.20 ± 0.20 ± 0.20		8.30 11.30 14.30
100020 100022 100025	10.00	15.00	± 0.30	1.10 0.89	9.96 9.87	1.60	± 0.10	20.00 22.00 25.00	± 0.23 ± 0.23 ± 0.23	1.00	16.30 18.30 21.30
100028 100030 100032								28.00 30.00 32.00	± 0.23 ± 0.23 ± 0.25		24.30 26.30 28.30
100035 100038 100040								35.00 38.00 40.00	± 0.25 ± 0.25 ± 0.25		31.30 34.30 36.30

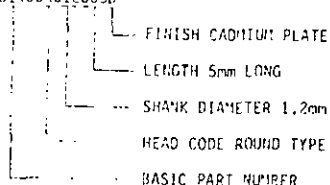
1/ FOR ROUND TYPE HEAD ONLY.

2/ FOR FLAT TYPE HEAD ONLY.

REQUIREMENTS:

1. MATERIAL. BRASS, PER QQ-B-613, 260 ANNEALED.
2. FINISH. CADMIUM PLATE PER QQ-P-415, CLASS 2, 7.6 μ m MINIMUM THICKNESS, TYPE II. (CODE - "D")
PLATING, TIN-LEAD, ELECTRODEPOSITED PER MIL-P-81728. (CODE - "T")
ELECTRODEPOSITED TIN-LEAD 7.6 μ m MINIMUM THICKNESS TO MEET SOLDERABILITY REQUIREMENTS OF MIL-STD-202, METHOD 208. MINIMUM THICKNESS DOES NOT APPLY AFTER FUSING (IF PERFORMED) BUT COATING MUST SHOW COMPLETE COVERAGE.
NO SUPPLEMENTARY FINISH (NO CODE).
3. RIVET HEADS. FLAT TYPE - "F", ROUND TYPE - "R".
4. PART NUMBER. THE BASIC PART NUMBER IS FOLLOWED BY A LETTER INDICATING HEAD TYPE AND A NUMBER CONSISTING OF SIX DIGITS.
THE FIRST THREE DIGITS INDICATE THE RIVET SHANK DIAMETER IN TENTHS OF MILLIMETERS.
THE SECOND THREE DIGITS DESIGNATE THE RIVET LENGTH IN MILLIMETERS.
THE LETTER AFTER THE SIX DIGIT NUMBER IS THE FINISH CODE LETTER.

EXAMPLE: D551403R0120050



NOTES:

1. DIMENSIONS. IN MILLIMETERS (mm). DIMENSIONING AND TOLERANCE PER ANSI Y14.5 - 1973.
2. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BIDS, OR REQUEST FOR PROPOSAL, EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.
3. FOR DESIGN PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

P. A. Other Cust. 99	International Interest	TITLE RIVET, TUBULAR, ROUND AND FLAT TYPE HEAD, METRIC	MILITARY STANDARD DS 51403
PROCUREMENT SPECIFICATION FF-R-556		SUPERSEDES.	PAGE 4 OF 4

FORM 672-1 (10-1974)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5320-0386

APPROVED 21 AUG 81 REVISED

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 this document, when applicable.

NOTICE
OF VALIDATION

METRIC
DS-51403
NOTICE 1
20 MAY 1988

MILITARY STANDARD
RIVET, TUBULAR, ROUND AND
FLAT TYPE HEAD, METRIC

DS-51403, dated 21 August 1981, has been reviewed and determined to be valid for use in acquisition.

Custodians:

Army - AR
Air Force - 99

Preparing activity:

Army - AR

Review activities:

Army - GL, MI
Navy - AS
NSA - NS
DLA - IS

User activities:

Army - AT, ME
Navy - MC

AMSC N/A

FSC 5320

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