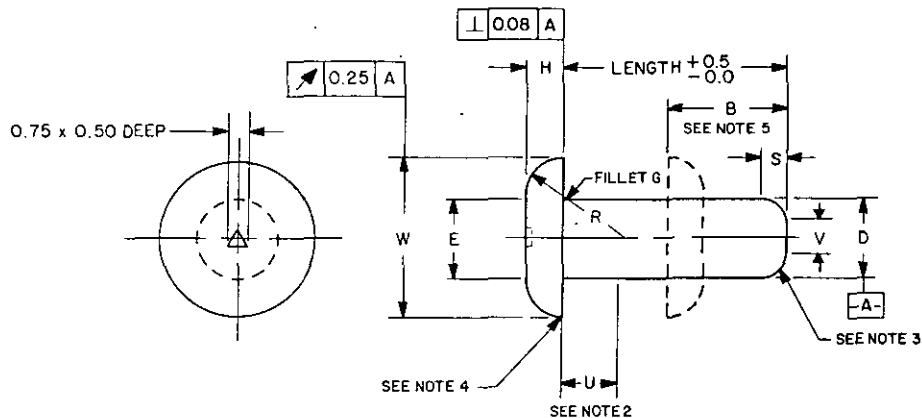


FED. SUP CLASS  
5320

## User activities:

ARMY - AT, ME  
NAVY - MC

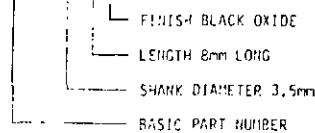
## Review activities:

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

## REQUIREMENTS:

1. MATERIAL. CARBON STEEL, FED. STD. NO. 66 COMPOSITION 1005 THRU 1022 ANNEALED AFTER HEADING.
2. FINISH. BLACK OXIDE - "B"; CADMIUM PLATE - "D" PER PROCUREMENT SPECIFICATION.
3. TOLERANCES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE  $\pm 0.25$ .
4. RIVETS SHALL DRIVE SATISFACTORILY WITH A FULL HEAD FREE FROM CRACKS.
5. PART NUMBER. THE BASIC PART NUMBER IS FOLLOWED BY A DASH 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: DS51405-03500BR



## NOTES:

1. DIMENSIONS. IN MILLIMETERS (mm). DIMENSIONING AND TOLERANCE PER ANSI Y14.5 - 1973.
2. SHANK DIAMETER INCREASE NOT EXCEEDING 0.03 IS PERMITTED TO LENGTH U. LENGTH U IS MEASURED FROM THE UNDERFACE OF THE HEAD TO A DISTANCE ALONG THE SHANK AND SHALL HAVE THE FOLLOWING VALUES:  
WHEN D IS  $\leq 4$ mm OR 4mm, U EQUALS  $1.3 + G$ ; WHEN D IS  $> 4$ mm, U EQUALS  $1.7 + G$  WHERE G IS THE UNDERHEAD RADIUS. VALUE U SHALL BE ROUNDED TO THE NEAREST 0.1mm.
3. FORM OF END IS AT MANUFACTURER'S OPTION BUT SHALL LIE BETWEEN A RADIUS TANGENTIAL TO THE SHANK AND A CHAMFER, AND SHALL NOT BE CONCAVE.
4. ROUNDED EDGE PERMISSIBLE WITHIN LIMITING DIMENSIONS.
5. APPROXIMATE MATERIAL FOR A FULL HEAD.
6. REFERENCE 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.
7. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

This military standard is approved for use by all Departments and 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	International interest	TITLE	MILITARY STANDARD
Other Cust.	99		RIVET, SOLID, UNIVERSAL HEAD, CARBON STEEL, METRIC	DS 51405
PROCUREMENT SPECIFICATION	FF-R-556	SUPERSEDES:		PAGE 1 OF 2

672-1 (Rev. 10-67)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5320-0396

METRIC

APPROVED 21 AUG 81 REVISED

## User activities:

ARMY - AT, ME  
NAVY - MC

## Review activities:

ARMY - GL, MI  
NAVY - AS  
DLA - IS  
NSA - NSFED. SUP CLASS  
5320

TABLE I.

NOM DIA	DIA PART NO	B REF	D DIA	E DIA MIN	G $\pm 0.08$	H $\pm 0.00$ -0.20	R	S	V	W DIA
1.6	016	2.40	1.58 1.52	1.20	0.15	0.89	2.01 1.89	0.62 0.32	1.28 0.98	3.36 3.04
2.0	020	3.00	1.98 1.92	1.50	0.15	1.06	2.50 2.38	0.70 0.40	1.60 1.30	4.20 3.80
2.5	025	3.80	2.48 2.42	1.88	0.15	1.28	3.11 2.99	0.80 0.50	2.00 1.70	5.25 4.75
3.0	030	4.50	2.98 2.92	2.25	0.15	1.49	3.72 3.60	0.90 0.60	2.40 2.10	6.30 5.70
3.5	035	5.30	3.47 3.40	2.63	0.25	1.71	4.33 4.21	1.05 0.70	2.80 2.45	7.35 6.65
4.0	040	6.00	3.97 3.90	3.00	0.25	1.92	4.94 4.82	1.20 0.80	3.20 2.80	8.40 7.60
5.0	050	7.50	4.97 4.90	3.75	0.25	2.35	6.16 6.04	1.50 1.00	4.00 3.50	10.50 9.50
6.0	060	9.00	5.97 5.90	4.50	0.25	2.78	7.38 7.26	1.80 1.20	4.80 4.20	12.60 11.40
8.0	080	12.00	7.96 7.87	6.00	0.25	3.64	9.82 9.70	2.40 1.60	6.40 5.60	16.80 15.20
10.0	100	15.00	9.96 9.87	7.50	0.25	4.50	12.27 12.14	3.00 2.00	8.00 7.00	21.00 19.00

TABLE II.

LENGTH (mm) $\pm 0.50$ -0.00		4.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	22.0	24.0	26.0	28.0	30.0	32.0	36.0	42.0	50.0	60.0
NOM DIA	DIA PART NO	LENGTH PART NO.																		
1.6	016	004	006	008	010	012	014													
2.0	020	004	006	008	010	012	014	016	018	020										
2.5	025		006	008	010	012	014	016	018	020	022	024	026							
3.0	030		006	008	010	012	014	016	018	020	022	024	026	028	030	032				
3.5	035			008	010	012	014	016	018	020	022	024	026	028	030	032				
4.0	040			008	010	012	014	016	018	020	022	024	026	028	030	032	036	042	050	
5.0	050				010	012	014	016	018	020	022	024	026	028	030	032	036	042	050	
6.0	060				010	012	014	016	018	020	022	024	026	028	030	032	036	042	050	060
8.0	080						014	016	018	020	022	024	026	028	030	032	036	042	050	060
10.0	100								018	020	022	024	026	028	030	032	036	042	050	060

P. A. Other Cust. 99	AR International interest	TITLE RIVET, SOLID, UNIVERSAL HEAD, CARBON STEEL, METRIC	MILITARY STANDARD DS 51405
PROCUREMENT SPECIFICATION FF-R-556	SUPERSEDES:	PAGE 2 OF 2	

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this document, when applicable.

APPROVED 21 AUG 81 REVISED

FORM 672-1 (1-1-64)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5320-0396

NOTICE  
OF VALIDATION

METRIC  
DS-51405  
NOTICE 1  
20 MAY 1988

MILITARY STANDARD  
RIVET, SOLID, UNIVERSAL HEAD,  
CARBON STEEL, METRIC

DS-51405, 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

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FSC 5320