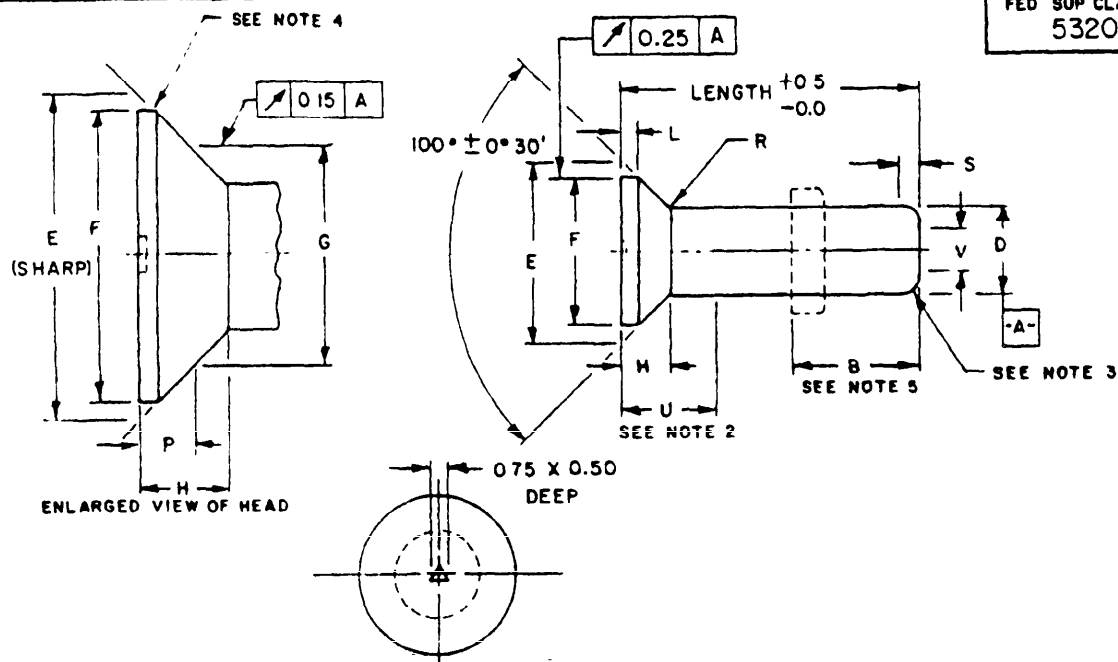


ARMY - R-1-AT
NAVY - MCARMY - M1
NAVY - AS
DLA - JS
NSA - NSFED SUP CLASS
5320

REQUIREMENTS

1. MATERIAL. CARBON STEEL, FED. STD. NO. 66 COMPOSITION 1010, 1015 ANNEALED AFTER HEADING.
2. FINISH. BLACK OXIDE - "B"; CADMIUM PLATE - "D" PER PROCUREMENT SPECIFICATION.
3. TOLERANCES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE ±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 DS51406-0250088

- FINISH BLACK OXIDE
- LENGTH 8mm LONG
- SHANK DIAMETER 2.5mm
- BASIC PART NUMBER

NOTES

1. DIMENSIONS. IN MILLIMETERS (mm). DIMENSIONING AND TOLERANCE PER ANSI Y14.5 - 1973.
2. SHANK DIAMETER INCREASE NOT EXCEEDING D MAX 0.03 IS PERMITTED TO LENGTH U. LENGTH U IS MEASURED FROM THE TOP OF THE HEAD TO A DISTANCE ALONG THE SHANK AND SHALL HAVE THE FOLLOWING VALUES WHEN D IS ≤ 4mm OR 4mm, U EQUALS 1.3 + H + R. WHEN D IS > 4mm, U EQUALS 1.7 + H + R WHERE H IS THE HEAD HEIGHT AND R 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. CURVED EDGE OPTIONAL 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 Other Cust	AR	International Interest	TITLE RIVET, SOLID, COUNTERSUNK 100° PRECISION HEAD, CARBON STEEL, METRIC	MILITARY STANDARD DS 51406
99			PROCUREMENT SPECIFICATION FF-R-556	PAGE 1 OF 2
			SUPERSEDES	

DD FORM 672-1 (Coordinated)
1 MAR 72

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5320-0397

METRIC

APPROVED 21 AUG 81 REVISED

FED SUP CLASS
5320User activities
ARMY - AT, MC
NAVY - MCReview activities
HI
ARMY - AS
NAVY - IS
DLA - IS
NSA - NS

TABLE I

NOM DIA (mm)	DIA PART NO	P REF	D DIA	E MAX	F MIN	G REF	H REF	L MAX	P		R ±0.08	S	V	U REF
									max	min				
1.6	016	2.40	1.58 1.52	3.00	2.80	2.48	0.59	0.08	0.22	0.14	0.15	0.62 0.32	1.28 0.98	2.00
2.0	020	3.00	1.98 1.92	3.70	3.50	3.10	0.71	0.08	0.25	0.17	0.15	0.70 0.40	1.60 1.30	2.20
2.5	025	3.80	2.48 2.42	4.65	4.40	3.88	0.90	0.11	0.32	0.24	0.15	0.80 0.50	2.00 1.70	2.30
3.0	030	4.50	2.98 2.92	5.55	5.25	4.65	1.07	0.13	0.38	0.30	0.15	0.90 0.60	2.40 2.10	2.50
3.5	035	5.20	3.47 3.40	6.50	6.15	5.43	1.26	0.15	0.45	0.37	0.25	1.05 0.70	2.80 2.45	2.80
4.0	040	6.00	3.97 3.90	7.40	7.00	6.20	1.43	0.17	0.50	0.42	0.25	1.20 0.80	3.20 2.80	3.00
5.0	050	7.50	4.97 4.90	9.25	8.75	7.75	1.78	0.21	0.63	0.55	0.25	1.50 1.00	4.00 3.50	3.70
6.0	060	9.00	5.97 5.90	11.10	10.50	9.30	2.14	0.25	0.76	0.68	0.25	1.80 1.20	4.80 4.20	4.10
8.0	080	12.00	7.96 7.87	14.80	14.00	12.40	2.85	0.34	1.01	0.93	0.25	2.40 1.60	6.40 5.60	4.80
10.0	100	15.00	9.96 9.87	18.50	17.50	15.50	3.57	0.42	1.26	1.18	0.25	3.00 2.00	8.00 7.00	5.50

TABLE II

NOM DIA (mm)	DIA PART NO	LENGTHS PART NUMBER (mm)																				+0.05 -0.00
		4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	36	42	50	60	70	
1.6	016	004	006	008	010	012	014	016														
2.0	020	004	006	008	010	012	014	016	018	020	022											
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	036	042	050			
3.5	035			008	010	012	014	016	018	020	022	024	026	028	030	032	036	042	050			
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	060		
6.0	060					012	014	016	018	020	022	024	026	028	030	032	036	042	050	060		
8.0	080							016	018	020	022	024	026	028	030	032	036	042	050	060	070	
10.0	100									020	022	024	026	028	030	032	036	042	050	060	070	

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this document, when applicable.

P A Other Cust.	AR	International Interest	TITLE RIVET, SOLID, COUNTERSUNK 100° PRECISION HEAD, CARBON STEEL, METRIC	MILITARY STANDARD DS 51406
99				
PROCUREMENT SPECIFICATION FF-R-556			SUPERSEDES	PAGE 2 OF 2

NOTICE
OF VALIDATION

METRIC
DS-51406
NOTICE 1
20 MAY 1988

MILITARY STANDARD

RIVET, SOLID, COUNTERSUNK 100⁰
PRECISION HEAD, CARBON STEEL, METRIC

DS-51406, 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 - MT
Navy - AS
NSA - NS
DLA - IS

User activities:

Army - AT, ME
Navy - MC

AMSC N/A

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FSC 5320