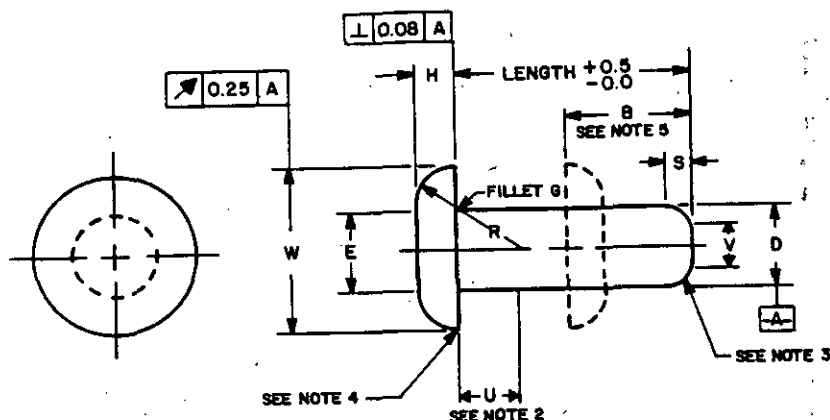


FED. SUP CLASS  
5320User activities:  
ARMY - AT, HE  
NAVY - MCReview activities:  
ARMY - GL, H1  
NAVY - AS  
DLA - IS  
NSA - NS

## REQUIREMENTS:

1. MATERIAL. COPPER, PER QQ-W-343, ANNEALED.
2. FINISH. WHEN SPECIFIED, 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.

EXAMPLE: 0551407-035018

LENGTH 18mm LONG  
SHANK DIAMETER 3.5mm  
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. U LENGTH IS MEASURED FROM THE UNDERFACE OF THE HEAD TO A DISTANCE ALONG THE SHANK AND SHALL HAVE THE FOLLOWING VALUES:  
WHEN D IS  $\leq 4mm$  OR  $4mm$ , U EQUALS  $1.3 + G$ ; WHEN D IS  $\geq 4mm$ , 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 MANUFACTURERS 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. 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.
7. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

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METRIC

APPROVED 21 AUG 81 REVISED

P. A. Other Cust.	AR 99	International interest	TITLE RIVET, SOLID, UNIVERSAL HEAD, COPPER, METRIC	MILITARY STANDARD DS 51407
PROCUREMENT SPECIFICATION FF-R-556		SUPERSEDES:		PAGE 1 OF 2

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.

DD FORM 672-1 (Coordinated)  
1 MAR 72

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5320-0401

FED. SUP CLASS  
5320

TABLE I.

NON DIA	DIA PART NO	B REF	D DIA	E DIA MIN	G ±0.08	H +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	0.28	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) +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	40.0	45.0	50.0
NON 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

APPROVED 21 AUG 81 REVISED

P. A. AR Other Cust. 99	International interest	TITLE RIVET, SOLID, UNIVERSAL HEAD, COPPER, METRIC	MILITARY STANDARD DS 51407
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