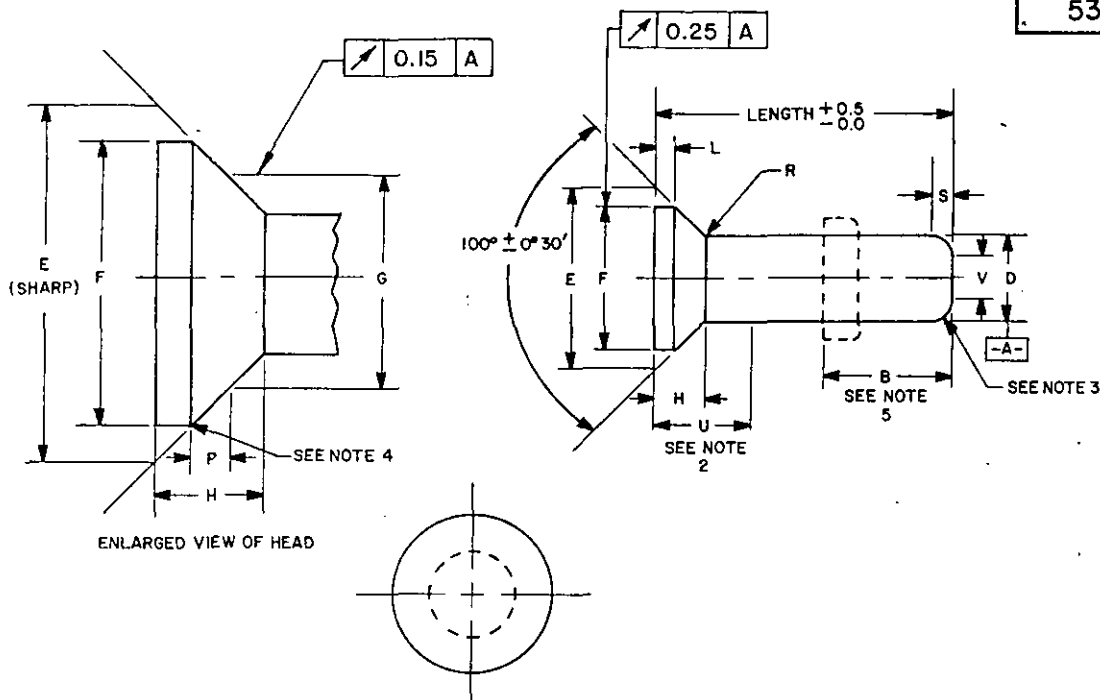


FED. SUP CLASS
5320

US&I activities:

ARMY - AT, ME
NAVY - MC

Review activities:

ARMY - GL, MI
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 ± 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: DS51408-016008

LENGTH 8mm LONG

SHANK DIAMETER 1.6mm

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 ≤ 4 mm OR 4mm, U EQUALS $1.3 + H + R$; WHEN D IS > 4 mm, U EQUALS $1.7 + H + R$ WHERE R 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. CURVED EDGE OPTIONAL 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.

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 | TITLE | MILITARY STANDARD |
| Other Cust. | YD | interest | RIVET, SOLID, COUNTERSUNK 100° | DS 51408 |
| | 99 | | PRECISION HEAD, COPPER, METRIC | |
| PROCUREMENT SPECIFICATION | | | SUPERSEDES: | PAGE 1 OF 2 |
| FF-R-556 | | | | |

DD FORM 672-1 (unclassified)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

*U.S. GOVERNMENT PRINTING OFFICE: 1981-703-023/6660

5320-0402

METRIC

APPROVED 21 AUG 81 REVISED

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

TABLE I.

| NOM. DIA. (mm) | DIA. PART NO. | D 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) ^{+0.5} _{-0.0} | | | | | | | | | | | | | | | | | | | |
|----------------------|--------------------|--|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|----|
| | | 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 | |

| | | | |
|---------------------------------------|---------------------------|---|---------------------------------------|
| P. A. Other Cust. YD 99 | International interest | TITLE RIVET, SOLID, COUNTERSUNK 100° PRECISION HEAD, COPPER, METRIC | MILITARY STANDARD DS 51408 |
| PROCUREMENT SPECIFICATION FF-R-556 | | SUPERSEDES: | PAGE 2 OF 2 |

NOTICE
OF VALIDATION

METRIC
DS-51408
NOTICE 1
20 MAY 1988

MILITARY STANDARD

RIVET, SOLID, COUNTERSUNK 100
PRECISION HEAD, COPPER, METRIC

DS-51408, dated 21 August 1981, has been reviewed and determined to be valid for use in acquisition.

Custodians:

Army - AR
Navy - YD
Air Force - 99

Preparing activity:

Army - AR

Review activities:

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

User activities:

Army - AT,
Navy - MC, MS

AMSC N/A

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

FSC 5320