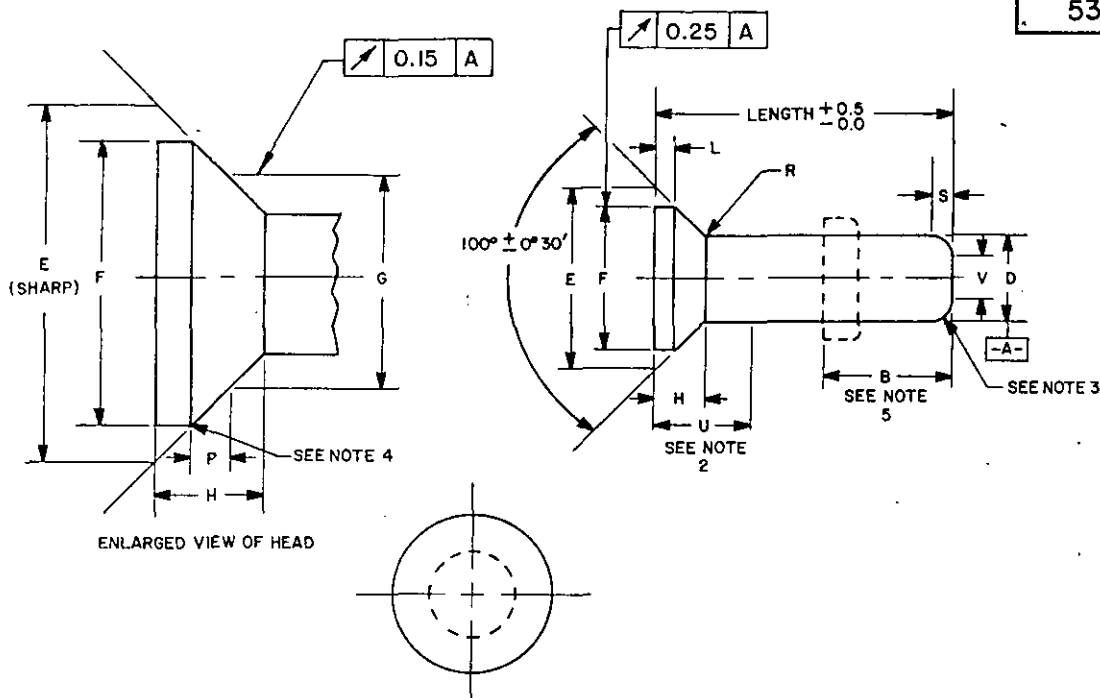


FED. SUP CLASS
5320

USGI 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

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