

FED. SUP CLASS

5320

1. APPLICATION

1.1 THESE RIVETS ARE INTENDED FOR USE IN RIVETED STRUCTURES WHERE FLUSHNESS, FATIGUE LIFE, STATIC JOINT STRENGTH AND CORROSION RESISTANCE ARE OF PRIMARY DESIGN IMPORTANCE.

1.2 RIVETS SHALL BE USED IN ACCORDANCE WITH MIL-STD-1515, REQUIREMENT 206.

2. MILITARY INSTALLATION MANUAL: NONE

3. MATERIALS

3.1 ALUMINUM ALLOYS PER QQ-A-430

MATERIAL LETTER CODE

3.1.1 2017-T4

D

3.1.2 2117-T4

AD

3.1.3 5056-H32

B

3.1.4 7050-T73

E

3.1.5 TITANIUM COLUMBIUM, 45 cb PER AMS 4982.

T

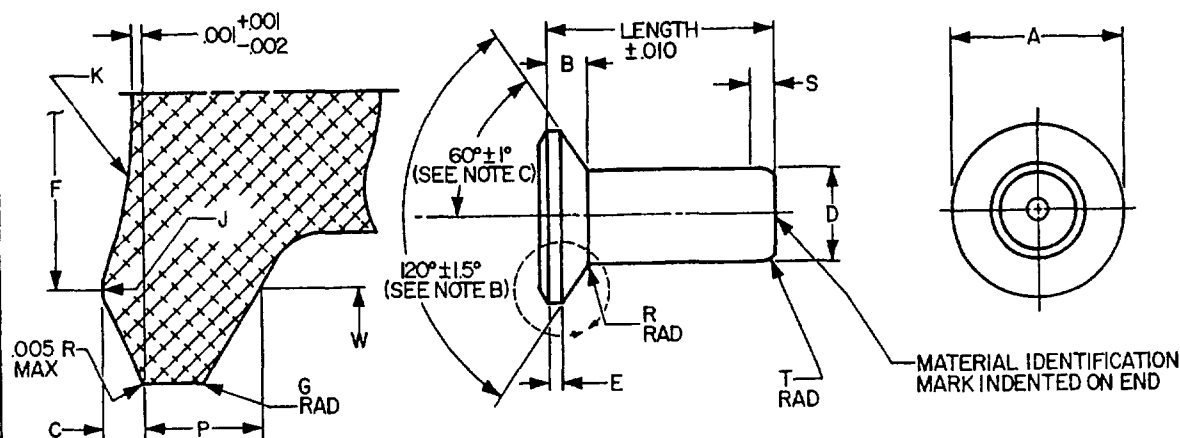
3.2 COATINGS, ALUMINUM ALLOYS.

(A) 3.2.1 ANODIZED PER MIL-A-8625, TYPE II, CLASS 1, DICHRONATE -
SEAL AT 203° TO 212° F.

3.2.2 CHEMICAL SURFACE TREATMENT PER MIL-C-5541, CLASS 1A. C

4. HEAT TREATMENT: IN ACCORDANCE WITH MIL-H-6088 FOR ALUMINUM ALLOYS. IN ACCORDANCE WITH AMS 4982 FOR TITANIUM COLUMBIUM ALLOYS.

5. ILLUSTRATION



(a) .001 SHANK DIAMETER INCREASE PERMISSIBLE WITHIN .100-INCH OF HEAD.

(b) THE 120° CONICAL SURFACE OF THE HEAD SHALL BE ANGULAR WITHIN .002 AND CONCENTRIC WITH THE SHANK OF THE RIVET WITHIN .003 TOTAL INDICATOR READING.

(c) HEAD COCKING ANGLE RELATIVE TO AXIS OF RIVET 1° MAXIMUM.

(d) THE RIVET CROWN (C DIMENSION) SHALL JOIN THE RIVET HEAD FLAT SURFACE SMOOTHLY WITHOUT ABRUPT SHOULDERS.

(A) DENOTES CHANGES

This standard has been approved by the NAVAL AIR SYSTEMS COMMAND Department of the NAVY and the Department of the AIR FORCE. All other military activities are required to employ this standard where suitable. be made from this document.

P.A. NAVY - AS Other Cust	TITLE RIVET, SOLID, 120° FLUSH INTERFERENCE, TENSION TYPE HEAD	MILITARY STANDARD MS14219(AS)
PROCUREMENT SPECIFICATION MIL-R-5674	SUPERSEDES:	
		SHEET 1 OF 3

DD FORM 1 SEP 71 672-1 (Limited coordination)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

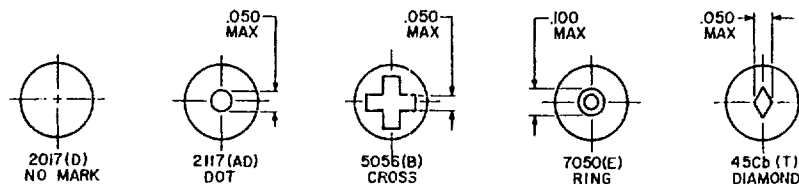
PROJECT NO. 5320-N021

PLATE NO. 17709

APPROVED 14 AUG 1984 REVISED (A) 25 JAN 85

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5.1 MATERIAL IDENTIFICATION SYMBOLS. SYMBOLS INDENTED .030 MAXIMUM DEPTH.



6. TABLE I. RIVET DIMENSIONS

DIA DASH NO.	NOM DIA	A + .000 - .002	B (REF)	C	D + .002 - .001	E MIN	F + .010	G RAD MAX	J RAD + .010	K RAD MIN	P		R RAD + .004	S + .010	T RAD + .010	W	
											MAX	MIN				GAGE MAX	DIA MIN
-3	3/32	.162	.034	.005 .009	.094	.013	.115	.005	.016	.060	.0305	.0284	.015	.023	.029	.1102	.1100
-4	1/8	.210	.041	.006 .010	.125	.014	.155	.005	.016	.100	.0361	.0339	.019	.031	.039	.1462	.1460
-5	5/32	.258	.053	.007 .011	.156	.021	.198	.005	.020	.125	.0448	.0424	.024	.039	.049	.1892	.1890
-6	3/16	.312	.068	.008 .012	.187	.030	.232	.006	.025	.125	.0541	.0513	.032	.047	.059	.2422	.2420
-7	7/32	.365	.077	.009 .013	.222	.033	.282	.007	.025	.156	.0655	.0629	.040	.054	.069	.2671	.2669
-8	1/4	.427	.090	.009 .013	.250	.036	.320	.009	.031	.188	.0760	.0733	.048	.062	.078	.3038	.3036
-9	9/32	.489	.100	.010 .014	.283	.038	.392	.010	.040	.218	.0874	.0848	.054	.068	.090	.3315	.3313
-10	5/16	.521	.104	.010 .014	.310	.040	.420	.010	.040	.250	.0725	.0687	.060	.078	.098	.4245	.4243

7. TABLE II. RIVET MECHANICAL PROPERTIES

ALLOY AND TEMPER	TENSILE STRENGTH psi MIN	YIELD STRENGTH psi MIN	ELONGATION IN 2 INCHES OR 4D % MIN	UNDRIVEN SHEAR STRENGTH psi	
				MIN	MAX
5056-H32	44,000	-----	-----	24,000	-----
2117-T4	38,000	18,000	18	26,000	-----
2017-T4	55,000	32,000	12	33,000	39,000
7050-T73	68,000	58,000	10	41,000	46,000
45 Cb	65,000	60,000	15	50,000	56,000

8. TABLE III. LENGTH NUMBERS

LENGTH (a)	DIAMETER DASH NUMBERS							
	-3	-4	-5	-6	-7	-8	-9	-10
.125	2	-	-	-	-	-	-	-
.156	2R	-	-	-	-	-	-	-
.188	3	3	3	-	-	-	-	-
.219	3R	3R	3R	-	-	-	-	-
.250	4	4	4	4	-	-	-	-
.281	4R	4R	4R	4R	-	-	-	-
.312	5	5	5	5	5	5	-	-
.343	5R	5R	5R	5R	5R	5R	-	-
.375	6	6	6	6	6	6	6	-
.406	6R	6R	6R	6R	6R	6R	6R	-
.438	7	7	7	7	7	7	7	7
.470	7R	7R	7R	7R	7R	7R	7R	7R
.500	8	8	8	8	8	8	8	8
.531	8R	8R	8R	8R	8R	8R	8R	8R

P.A.
NAVY-AS
Other Cust

TITLE

RIVET, SOLID, 120° FLUSH INTERFERENCE, TENSION TYPE HEAD

MILITARY STANDARD

MS14219(AS)

PROCUREMENT SPECIFICATION
MIL-R-5674

SUPERSEDES:

SHEET 2 OF 3

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LENGTH (a)	DIAMETER DASH NUMBERS							
	-3	-4	-5	-6	-7	-8	-9	-10
.562	9	9	9	9	9	9	9	9
.593	9R	9R	9R	9R	9R	9R	9R	9R
.625	10	10	10	10	10	10	10	10
.687	11	11	11	11	11	11	11	11
.750	12	12	12	12	12	12	12	12
.812	-	13	13	13	13	13	13	13
.875	-	14	14	14	14	14	14	14
.937	-	15	15	15	15	15	15	15
1.000	-	16	16	16	16	16	16	16
1.062	-	-	17	17	17	17	17	17
1.125	-	-	18	18	18	18	18	18
1.187	-	-	19	19	19	19	19	19
1.250	-	-	20	20	20	20	20	20
1.312	-	-	21	21	21	21	21	21
1.375	-	-	22	22	22	22	22	22
1.437	-	-	23	23	23	23	23	23
1.500	-	-	24	24	24	24	24	24
1.625	-	-	-	26	26	26	26	26
1.750	-	-	-	28	28	28	28	28
1.875	-	-	-	-	-	30	30	30
2.000	-	-	-	-	-	32	32	32

- (a) RIVET BODY SHALL HAVE A RADIUS END EXCEPT THAT LENGTH IN SHADED AREA MAY HAVE A SQUARED END.
REVISED ALL LENGTHS TO 0.0625 INCREMENTS; R DESIGNATES 0.031 INCREASED LENGTHS.

9. EXAMPLE OF PART NUMBER:

MS14219 AD 10 - 12 R
 ———— MATERIAL LETTER CODE
 ———— DIAMETER DASH NUMBERS IN .031-INCH INCREMENTS
 { "A" ANODIZED
 { "C" CHEMICAL SURFACE TREATMENT
 ———— LENGTH DASH NUMBERS IN .0625-INCH INCREMENTS
 ———— INCREASED LENGTH BY .031-INCH

10. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
11. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BIDS OR REQUEST FOR PROPOSAL EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.
12. THE RIVETS ARE A PROPRIETARY PRODUCT OF BRILES RIVET CORPORATION AND ARE COVERED BY PATENT NO. 4,159,666 EXPIRING 3 JULY 1996. THE UNITED STATES GOVERNMENT DOES NOT HAVE A ROYALTY-FREE LICENSE.

This standard has been approved by the NAVAL AIR SYSTEMS COMMAND Department of the NAVY and that activity. All other military activities are required to employ this standard where suitable.

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PROCUREMENT SPECIFICATION MIL-R-5674	SUPERSEDES:	MS14219(AS)
		SHEET 3 OF 3