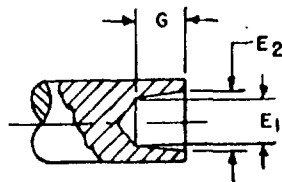
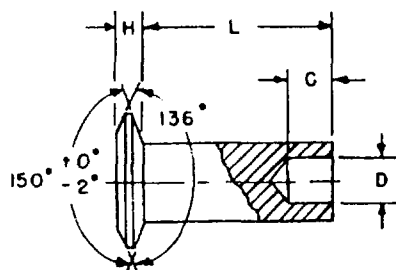


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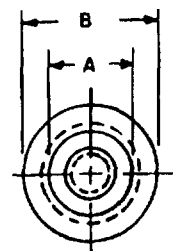


TABLE 1

NOMINAL SIZE		.125		.146		.166		.252	
		MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX
BODY DIAMETER	A	0.116	0.123	0.141	0.146	0.162	0.168	0.244	0.252
HEAD DIAMETER	B	.245	.255	.289	.303	.351	.367	.458	.478
HEAD THICKNESS	H	.030	.036	.035	.045	.041	.051	.053	.067
STRAIGHT HOLE	D	.064	.090	.089	.105	.133	.139	.173	.183
TAPER AT BOTTOM OF HOLE	E1	.079		.065		.110		.150	
TAPER AT END OF RIVET	E2	.091	.095	.106	.112	.139	.145	.181	.191
HOLE DEPTH (TAPER)	G	.082		.104		.135		.183	
HOLE DEPTH (STRAIGHT) NOM.	C	0.094		0.126		0.155		0.219	
CLINCH ALLOWANCE *		.074		.088		.120		.164	

* For reference only. Optimum values vary with characteristics of material to be riveted, and should be determined by actual test if possible.

NOTES:

- MATERIAL:** Steel, carbon, per Federal Standard No. 66, steel numbers C1005 thru C1022.
Brass, quarter hard, per QQ-W-321, composition 260 or 270.
Aluminum alloy, per QQ-A-430, composition 2117-T4 or 5056-H32.
Nickel-Copper alloy (Monel), per QQ-N-281, class A, No. 0 temper.
Copper, per QQ-W-343, type S.
- PROTECTIVE COATING:** Steel, carbon, cadmium plated per QQ-P-416, type II, class 2.
Brass, oxide or black finish per MIL-F-493 or nickel plating per QQ-N-290, class 1, fully bright, 0.0002 thk.
Aluminum alloy, composition 2117-T4, anodized per MIL-A-8625 or given a chemical film per MIL-C-5541.
It is not necessary to anodize composition 5056-H32 aluminum rivets.
- DOUBLE STRENGTH:** Carbon Steel Rivets 32,000 P.S.I. Min.
Brass Rivets 35,000 P.S.I. Min.
Aluminum Rivets (2117) 26,000 P.S.I. Min.
Aluminum Rivets (5056) 24,000 P.S.I. Min.
Nickel Alloy (Monel) Rivets 49,000 P.S.I. Min.
Copper Rivets 24,000 P.S.I. Min.
- DIMENSIONS:** All dimensions are in inches.
- TOLERANCES:** ±.005 for decimal dimensions, unless otherwise specified.
Length tolerances shall be in agreement with AMS B18.7.
- PART NUMBER:** The MS part number consists of the MS number, plus the dash number, plus the code letter, when applicable.
Code letters:
Add "N" as suffix to dash number for nickel plating to brass material.
Add "A" in lieu of dash number for aluminum alloy, composition 5056-H32.
Example:
MS16536-1 Rivet, Carbon Steel.
MS16536-16 Rivet, Brass, Oxide or Black Chemical Finish.
MS16536-16N Rivet, Brass, Nickel Plate Finish.
MS16536-3J Rivet, Aluminum Alloy, Composition No. 2117-T4.
MS16536A3J Rivet, Aluminum Alloy, Composition No. 5056-H32.
- For design feature purposes, this standard takes precedence over procurement documents referenced herein.
- Referenced documents shall be of the issue in effect on date of invitations for bid.

Ⓐ ENTIRE STANDARD REVISED

P.A. 60	TITLE	MILITARY STANDARD
Other Cost 82	RIVET - TUBULAR, 150° FLAT COUNTERSUNK HEAD	MS16536
PROCUREMENT SPECIFICATION FF-R-556	SUPERSEDES	SHEET 1 OF 2

DD FORM 672-1 (Continued)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

REVIEWER: LS, MI, ML, NSA, AS
USER: AS, AT, EL, GL, MC, SD

This military standard is mandatory 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.

APPROVED 5 DEC 1957 REVISED Ⓐ 12 NOV 1969

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TABLE 11

LENGTH L	CARBON STEEL	BRASS	ALUMINUM ALLOY	NICKEL- COPPER ALLOY	COPPER	LENGTH L	CARBON STEEL	BRASS	ALUMINUM ALLOY	NICKEL- COPPER ALLOY	COPPER
DASH NUMBERS						DASH NUMBERS					
NOMINAL SIZE .123						NOMINAL SIZE .188					
.250	1	16	31	46	61	.250	151	168	185	202	219
.281	2	17	32	47	62	.281	152	169	186	203	220
.312	3	18	33	48	63	.312	153	170	187	204	221
.344	4	19	34	49	64	.344	154	171	188	205	222
.375	5	20	35	50	65	.375	155	172	189	206	223
.406	6	21	36	51	66	.406	156	173	190	207	224
.438	7	22	37	52	67	.438	157	174	191	208	225
.469	8	23	38	53	68	.469	158	175	192	209	226
.500	9	24	39	54	69	.500	159	176	193	210	227
.531	10	25	40	55	70	.531	160	177	194	211	228
.562	11	26	41	56	71	.562	161	178	195	212	229
.594	12	27	42	57	72	.594	162	179	196	213	230
.625	13	28	43	58	73	.625	163	180	197	214	231
.688	14	29	44	59	74	.656	164	181	198	215	232
.750	15	30	45	60	75	.688	165	182	199	216	233
						.719	166	183	200	217	234
						.750	167	184	201	218	235
NOMINAL SIZE .146						NOMINAL SIZE .252					
.250	76	91	106	121	136	.312	236				
.281	77	92	107	122	137	.344	237				
.312	78	93	108	123	138	.375	238				
.344	79	94	109	124	139	.406	239				
.375	80	95	110	125	140	.438	240				
.406	81	96	111	126	141	.469	241				
.438	82	97	112	127	142	.500	242				
.469	83	98	113	128	143	.531	243				
.500	84	99	114	129	144	.562	244				
.531	85	100	115	130	145	.594	245				
.562	86	101	116	131	146	.625	246				
.594	87	102	117	132	147	.656	247				
.625	88	103	118	133	148	.688	248				
.688	89	104	119	134	149	.719	249				
.750	90	105	120	135	150	.750	250				
						1.000	251				
						1.250	252				
						1.500	253				

REVIEWER: IS, MI, MC, NSA, 85
USER: AS, AT, EL, CL, MC, YD

This military standard is mandatory 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.

APPROVED 5 DEC 1957 REVISED ④ FOR CHANGES SEE SHEET 1

P.A. WC Other Case 82	TITLE RIVET - TUBULAR, 150° FLAT COUNTERSUNK HEAD	MILITARY STANDARD MS16536
PROCUREMENT SPECIFICATION FF-R-556	SUPERSEDES:	SHEET 2 OF

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.