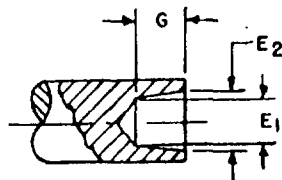
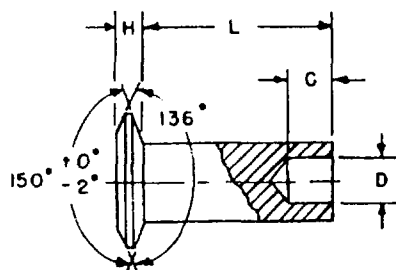


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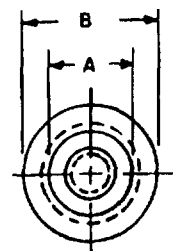


TABLE 1

| 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<br>L       | CARBON<br>STEEL | BRASS | ALUMINUM<br>ALLOY | NICKEL-<br>COPPER<br>ALLOY | COPPER | LENGTH<br>L       | CARBON<br>STEEL | BRASS | ALUMINUM<br>ALLOY | NICKEL-<br>COPPER<br>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<br>Other Cont<br>82           | TITLE<br>RIVET - TUBULAR, 150° FLAT COUNTERSUNK HEAD | MILITARY STANDARD<br>MS16536 |
| PROCUREMENT SPECIFICATION<br>FF-R-556 | SUPERSEDES:  | SHEET 2 OF                   |

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.