Downloaded from http://www.everyspec.com

USER SYMBOLS:
ARMY - MI

REVIEWER SYMBOLS:
ARMY - 99
USAF - 15
DLA - IS

"Review/user information is current as of the date of this document. For future coordination of changes to this document, draft circulation should be based on the information in the current DODISS."

This military standard is approved for use by all Departments & Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

FED. SUP CLASS
5320

BLIND RIVETS SHALL BE USED IN COMPLIANCE WITH THE JOINT ALLOWABLE TABLES IN MIL-HDBK-5, CHAPTER 8.

BLIND RIVETS SHALL CONFORM TO THE FOLLOWING REQUIREMENTS:

1. THE HOLE SIZE FOR BLIND INSTALLATION SHALL BE WITHIN THE LIMITS SPECIFIED ON THE APPLICABLE SPECIFICATION SHEET, STANDARD, OR DRAWING.

2. FOR DIMPLED ASSEMBLY, THE RIVET HOLES SHALL BE SIZED AFTER THE SHEETS HAVE BEEN DIMPLED.

3. MECHANICALLY LOCKED SPINDLE BLIND RIVETS (LOCKING RING OR COLLAR) MAY BE USED ON AIRCRAFT IN AIR INTAKE AREAS AND IN THE AREA FORWARD OF THE ENGINE.

4. FOR REPAIR AND REWORK, THE BLIND RIVETS USED IN REPLACEMENT OF SOLID SHANK RIVETS SHALL BE OVERSIZE OR ONE STANDARD SIZE LARGER (SEE REQMT 5).

5. OVERSIZE BLIND RIVETS MAY BE USED FOR REPAIR AND REWORK:

   a. OVERSIZE RIVETS ARE FOR USE IN NON-STANDARD HOLE DIAMETERS. NON-STANDARD HOLES ARE THE RESULT OF HOLE RESIZING DURING REWORK OR REPAIR, OR DUE TO MANUFACTURING ERROR IN NEW DESIGN.

   b. THE GRIP LENGTH OF THE OVERSIZE RIVET, THE BACKSIDE CLEARANCE (INSTALLED AND UNINSTALLED), AND THE PERFORMANCE CHARACTERISTICS SHALL BE EQUAL TO THE STANDARD RIVET THAT IS BEING REPLACED.

6. BLIND RIVETS SHALL NOT BE USED:

   a. IN FLUID TIGHT AREAS.

   b. ON AIRCRAFT CONTROL SURFACE HINGES, HINGE BRACKETS, FLIGHT CONTROL ACTUATING SYSTEMS, WING ATTACHMENT FITTINGS, LANDING GEAR FITTINGS, OR OTHER HEAVILY STRESSED LOCATIONS ON THE AIRCRAFT.

7. FRICTION LOCKED BLIND RIVETS (NO LOCKING RING OR COLLAR) SHALL NOT BE USED ON AIRCRAFT IN AIR INTAKE AREAS WHERE RIVET PARTS MAY BE INGESTED BY THE ENGINE.

8. NICKEL-COPPER ALLOY (MONEL) RIVETS WITH CADMIUM PLATING SHALL NOT BE USED WHERE THE AMBIENT TEMPERATURE IS ABOVE 400°F.

9. FLUSH HEAD RIVETS SHALL NOT BE MILLED TO OBTAIN FLUSHNESS WITH THE SURROUNDING SHEET WITHOUT PRIOR WRITTEN APPROVAL FROM THE DESIGN ACTIVITY.

10. OVERSIZE BLIND RIVETS SHALL NOT BE SPECIFIED IN NEW DESIGN. AN OVERSIZE BLIND RIVET IS ONE SPECIFICALLY DESIGNED FOR REPLACEMENT PURPOSES. ITS SHANK DIAMETER DIMENSION IS GREATER THAN A STANDARD BLIND RIVET.

11. CHEMICALLY EXPANDED BLIND RIVETS SHALL NOT BE USED.

THIS IS A DESIGN STANDARD, NOT TO BE USED AS A PART NUMBER.

(C) REWRITTEN

APPROVED 11 APR 52 REVISED (C) 19 OCT 84

P.A.
NAVY — AS
Other Cust
ARMY - AV
USAF - 11

TITLE
RIVETS, BLIND, STRUCTURAL, MECHANICALLY LOCKED AND FRICTION RETAINER SPINDLE, (RELIABILITY AND MAINTAINABILITY) DESIGN AND CONSTRUCTION REQUIREMENTS FOR.

MILITARY STANDARD

MS33522

PROCUREMENT SPECIFICATION

SUPERSEDES:

SHEET 1 OF 1

DD FORM 1 MAR 72 672-1 (Coordinated) PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PROJECT NO. 5320-0375

PLATE NO. 23005