

USER SYMBOL:

REVIEWER SYMBOLS:

ARMY - AR
AF-99
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.

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

THIS DOCUMENT HAS BEEN PROMULGATED BY THE DEPARTMENT OF DEFENSE TO LIMIT THE SELECTION OF NON-STRUCTURAL RIVETS IN ENGINEERING AND DESIGN.

USE OF NON-STRUCTURAL RIVETS FOR BLIND ATTACHMENT SHALL BE SUBJECT TO THE FOLLOWING LIMITATIONS:

- (a) FOR NON-STRUCTURAL USE ON MILITARY AIRCRAFT AND OTHER MILITARY EQUIPMENT.
- (b) NOT FOR USE IN APPLICATIONS WHERE FAILURE OF THE RIVET WOULD ENDANGER SAFETY OF PERSONNEL OR CAUSE MALFUNCTIONING OF EQUIPMENT OR AIRCRAFT.
- (c) THEY MAY BE USED IN APPLICATIONS SUCH AS:
FASTENING NAME, WARNING, AND INSTRUCTION PLATES.
ASSEMBLY OF NONSTRUCTURAL COMPONENTS.
SECURING PLATE NUTS WHEN IT IS EVIDENT THAT RIVETS POSSESS ADEQUATE STRENGTH TO WITHSTAND SPECIFIED NUT PUSH OUT AND TORQUE-OUT LOADS

RECOMMENDED USE

RIVET DIAMETER	HOLE LIMITS
3/32	.097 - .101
1/8	.129 - .132
5/32	.160 - .164
3/16	.192 - .196
1/4	.256 - .263

(A)

WHEN MILLING OF COUNTERSUNK RIVETS IS REQUIRED TO OBTAIN FLUSHNESS, THE RIVET HEADS SHALL NOT PROTRUDE MORE THAN .005 ABOVE THE SURROUNDING SHEET PRIOR TO MILLING.

WHEN DRIVE PIN-TYPE NON-STRUCTURAL RIVETS ARE UTILIZED, SUFFICIENT SUPPORT MUST EXIST TO WITHSTAND THE FORCES NECESSARY TO DRIVE THE PINS.

CADMIUM-PLATED, NICKEL-COPPER ALLOY (MONEL) RIVETS SHALL NOT BE USED IN APPLICATIONS WHERE THE AMBIENT TEMPERATURE IS ABOVE 400°F.

STRUCTURAL RIVETS MAY BE USED FOR REPLACEMENT.

DIMENSIONS ARE IN INCHES.

APPROVED 6 JUNE 1957 REVISED (A) 15 SEPTEMBER 1981

(A) REVISED

P.A. NAVY - AS Other Cust NAVY - AS AF - 11 ARMY - AV	TITLE	MILITARY STANDARD
	NONSTRUCTURAL RIVETS FOR BLIND ATTACHMENT; LIMITATIONS FOR DESIGN AND USAGE	MS33557
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 1