

REVIEW: GL, IS, MI, MU, NSA
USER: AS, EL, MC, SN

NOMINAL SIZE		0.123		0.146		0.165	
		MIN	MAX	MIN	MAX	MIN	MAX
BODY DIAMETER	A	0.115	0.123	0.141	0.146	0.152	0.155
HEAD DIAMETER	B	.213	.223	.307	.317	.369	.381
HEAD THICKNESS	H	.034	.041	.042	.052	.057	.067
STRAIGHT HOLE	D	.084	.090	.100	.107	.134	.141
TAPER AT BOTTOM OF HOLE	E ₁	.079	---	.091	---	.120	---
TAPER AT END OF RIVET	E ₂	.091	.093	.106	.112	.139	.145
FILLET	F	---	.016	---	.020	---	.023
HOLE DEPTH (TAPER)	G	.052	---	.104	---	.135	---
HOLE DEPTH (STRAIGHT)	C	.059	.104	.120	.135	.151	.166
CLINCH ALLOWANCE *		.074		.085		.120	
LENGTH L		STEEL			BRASS		
		DASH NUMBER			DASH NUMBER		
		0.123	0.146	0.155	0.123	0.146	0.155
3/32	0.094	1			50		
1/8	.125	2			51		
5/32	.156	3			52		
3/16	.187	4	17		53	66	
7/32	.219	5	18		54	67	
1/4	.250	6	19	32	55	68	
9/32	.281			33		69	
5/16	.312	8	21	34	57	70	84
3/8	.375	9	22	35	58	71	
1/2	.500		24	37		73	86
9/16	.562		25	38		74	
5/8	.625		26	39		75	

* For reference only. Optimum values vary with characteristics of materials 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, per QQ-b-321, composition 260 or 270, quarter hard.
- PROTECTIVE COATING:** Uncoated.
- DOUBLE SHEAR STRENGTH:** Carbon steel rivets 32,000 P.S.I. Min.
Brass rivets 35,000 P.S.I. Min.
- DIMENSIONS:** Dimensions are in inches.
- TOLERANCES:** .0003 for decimal dimensions, unless otherwise specified.
Length tolerances shall be in agreement with ANSI B19.7.
- PART NUMBER:** The MS part number consists of the MS number, plus the dash number.
Example: MS51942-1.
- The hole depth to point of Apex shall not be greater than the shank length.
- 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.

(A) ENTIRE STANDARD REVISED

P.A. VC Other Code TD	TITLE RIVET, TUBULAR - FLAT HEAD	MILITARY STANDARD MS51942
PROCUREMENT SPECIFICATION FF-R-556	SUPERSEDES ENCL1	SHEET 1 OF 1

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.