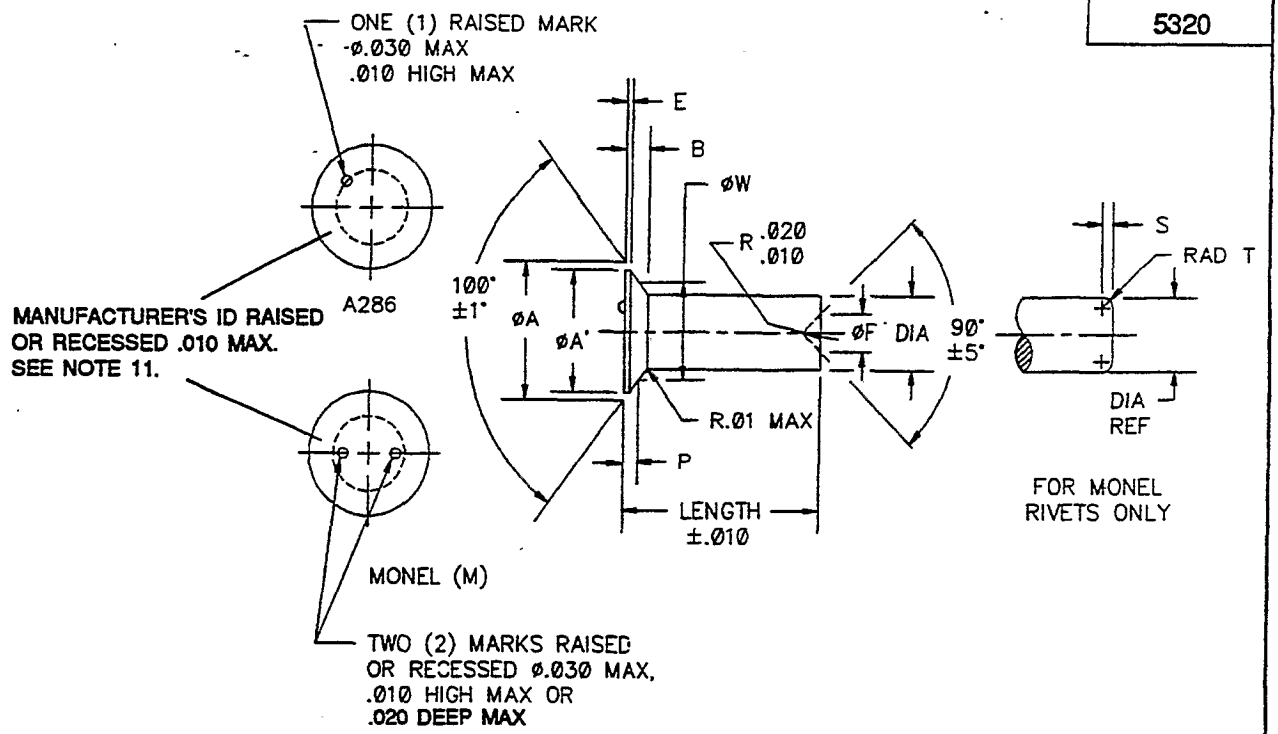
Aerospace Industries Association

NATIONAL AEROSPACE STANDARD

FED SUP CLASS
5320



DIA	Ø A	Ø A' ABSOLUTE MIN	B (REF)	E MAX	Ø F ±.005	P		Ø W		S	T RAD
						MAX	MIN	MAX	MIN		
.094 +.002 -.001	.1490 .1398	.1260	.021	.006	NO RECESS	.0123	.0089	.1192	.1190	.023	.029
.125 +.003 -.001	.1970 .1874	.1739	.029	.006	.070	.0141	.0106	.1628	.1626	.031	.039
.156 +.004 -.001	.2487 .2384	.2251	.037	.006	.080	.0189	.0153	.2028	.2026	.039	.049
.187 +.004 -.001	.2987 .2879	.2749	.046	.006	.100	.0225	.0188	.2441	.2439	.047	.059
.250 +.004 -.001	.3953 .3835	.3710	.060	.008	.125	.0263	.0223	.3315	.3313	.062	.078

LIST OF CURRENT SHEETS
(9)

NO.	REV.
1	9
2	4

CUSTODIAN **NATIONAL AEROSPACE STANDARDS COMMITTEE**

THIRD ANGLE PROJECTION

PROCUREMENT SPECIFICATION
NONE

TITLE
RIVET, SOLID, 100 DEG FLUSH SHEAR HEAD, A286 CORROSION RESISTANT STEEL AND MONEL

CLASSIFICATION
STANDARD PART

NAS1200

SHEET 1 OF 2

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1250 EYE STREET, N.W.
WASHINGTON, D.C. 20005

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST DATE OF APPROVAL SHOWN HEREON.

APPROVAL DATE MARCH 1959 REVISION (3) 30 SEPT. 1967 (4) 31 MAY 1974 (5) 13 NOV. 1978 (6) 25 APRIL 1991 (7) 6 DEC. 1991 (8) 31 JULY 1993 (9) 17 DEC. 1993

BASIC PART NUMBER	DIA	LENGTHS AND DASH NUMBERS										
		.125	.188	.250	.312	.375	.438	.500	.563	.625	.688	.750
NAS1200-3	.094	-2	-3	-4	-5	-6	-7	-8	-9	-10	-11	-12
NAS1200-4	.125		-3	-4	-5	-6	-7	-8	-9	-10	-11	-12
NAS1200-5	.156			-4	-5	-6	-7	-8	-9	-10	-11	-12
NAS1200-6	.187			-4	-5	-6	-7	-8	-9	-10	-11	-12
NAS1200-8	.250				-5	-6	-7	-8	-9	-10	-11	-12

BASIC PART NUMBER	DIA	LENGTHS AND DASH NUMBERS									
		.813	.875	.938	1.000	1.125	1.250	1.375	1.500	1.750	2.000
NAS1200-3	.094	-13	-14	-15	-16						
NAS1200-4	.125	-13	-14	-15	-16	-18	-20				
NAS1200-5	.156	-13	-14	-15	-16	-18	-20	-22	-24	-28	-32
NAS1200-6	.187	-13	-14	-15	-16	-18	-20	-22	-24	-28	-32
NAS1200-8	.250	-13	-14	-15	-16	-18	-20	-22	-24	-28	-32

NOTE: MONEL RIVETS WITH LENGTHS TO THE RIGHT OF THE HEAVY LINE ARE NOT AVAILABLE WITH RADIUSED ENDS

MATERIAL: A286 (UNS S66286) - Corrosion and heat resistant wire per AMS5734.
MONEL (UNS N04400) - Nickle-Copper-Alloy wire per QQ-N-281, Class A (Annealed).

SHEAR STRENGTH AT ROOM TEMPERATURE:
A286 - 85 KSI TO 95 KSI as heat treated.
90 KSI MIN after driving.
MONEL - 49 KSI TO 59 KSI, as received.
See Note 12.

HEAT TREAT: A286 - Solution treat and partially precipitation heat treat after after heading as follows:
Heat at 1650 F +/- 25 for 25 minutes - Oil quench.
Age at 1250 F to 1350 F for 30 to 90 minutes as necessary to meet shear requirements.
Air Cool.

FINISH: A286 - Passivate per QQ-P-35.
MONEL - Only when specified, CADMIUM plate per QQ-P-416, TYPE II, CLASS 2.

CODE: "M" in place of first dash indicates MONEL.
"P" after last dash number indicates Cadmium plate for MONEL only.

EXAMPLES OF PART NUMBERS:

NAS1200-4-8 = .125 DIA, .500 LENGTH, A286 RIVET
NAS1200M4-8 = .125 DIA, .500 LENGTH, MONEL RIVET, NO FINISH
NAS1200M4-8P = .125 DIA, .500 LENGTH, MONEL RIVET, CADMIUM PLATED
NAS1200-4-8-5 = .125 DIA, .531 LENGTH, A286 RIVET (SEE NOTE 10)

NOTES:
1. Tolerances: Unless otherwise specified ± .010.
2. .001 shank diameter increase permissible within .10 inches of base of head.
3. Shank and head diameters shall be concentric within .010 for rivets thru .125, within .015 for .156 and .187 rivets, and within .020 for .250 rivets, FIM.
4. Rivets shall drive cold satisfactorily with full heads free from cracks.
5. Rivets must be of uniform quality and free from scale, fins, seams, clinch or die marks, cold shuts, or other injurious defects.
6. Head cocking angle relative to axis of rivet .500 deg MAX.
7. Maximum head diameters are to theoretical sharp corners as measured by projection.
8. See NAS527 for the recommended practice for inspecting head characteristics.
9. The head periphery may be rounded within the "E" dimension.
10. Additional .0313 increments may be obtained by adding -5 after the last digit of part number.
11. (4) Manufacturer's identification is required on rivet heads with shank diameter .125 inch and larger manufactured after June 1993.
12. Double shear strength tests shall be in accordance with MIL-STD-1312, Test 13 or ASTM B565. Single shear strength testing per MIL-STD-1312, Test 20.

APPROVED DATE MAY 1974 REVISION (1) 25 APRIL 1991 (2) 6 DEC. 1991 (3) JULY 1993 (4) 17 DEC. 1993