



TABLE I

DIAMETER DASH NUMBER	RIVET SIZE NOMINAL	A DIA. (c) +.0035 -.0010	B DIA. (d) ±.004	C (REF)	D (g)		E AL ALLOY, A286 & MONEL	G MINIMUM	HOLE LIMIT +.0000 -.0020
					AL ALLOY	A286 & MONEL			
-04	.125	.125	.225	.042				.788	.1320
-05	.156	.156	.286	.055	100° ± 1.0°	100° ± 1.5°	.002 TO .015	.788	.1640
-06	.190	.187	.353	.070				.788	.1960
-08	.250	.250	.476	.095				1.000	.2610

- (a) .001 SHANK DIAMETER INCREASE PERMISSIBLE WITHIN .100 FROM BASE OF HEAD.
- (b) MARKING OF ALUMINUM RIVETS MAY BE ON SPINDLE AT MANUFACTURER'S OPTION.
- (c) "A" DIAMETER MAY BE .001 LARGER THAN SHOWN FOR CADMIUM PLATED OR ALUMINUM COATED SLEEVES.
- (d) "B" IS THE THEORETICAL INTERSECTION DIAMETER FOR COUNTERSINK.
- (e) BELOW .078 SHEET THICKNESS FOR .125 DIAMETER AND .100 FOR .156 DIAMETER DOUBLE DIMPLING IS RECOMMENDED. IF DOUBLE DIMPLING CANNOT BE PERMITTED, USE GRIP DASH NUMBER 01. BELOW .100 FOR .190 DIAMETER AND .126 FOR .250 DIAMETER, DOUBLE DIMPLING IS RECOMMENDED.
- (f) "A" DIAMETER MAY BE .001 SMALLER BEYOND MINIMUM GRIP LENGTH.
- (g) HEAD ANGLE "D" FOR RIVETS WITH "S" IN THE PART NUMBER MAY BE 108° MAXIMUM AND ARE FOR INSTALLATION OF COUNTERSINKS PER "D" IN ABOVE TABLE.
- (h) RIVETS FOR USE WITH SINGLE ACTION (NON-SHIFTING) TOOLING SHALL BE IDENTIFIED WITH A DEPRESSED "S" ON SPINDLE HEAD OR COLOR CODED YELLOW ON SPINDLE, LOCATION OPTIONAL.
- (j) DRIVE ANVIL WASHER USED FOR "U" CODE IS MADE FROM ALLOY STEEL AND FINISHED WITH A BLACK OXIDE COATING PER MIL-DTL-13924 OR CADMIUM PLATED, TYPE I, CLASS 3 PER AMS-QQ-P-416 AT MANUFACTURERS OPTION.

TABLE II

GRIP DASH NO.	AF1921*04 (.125 DIA)				AF1921*05 (.156 DIA)				AF1921*06 (.190 DIA)				AF1921*08 (.250 DIA)								
	GRIP MIN	GRIP MAX	LENGTH MIN	LENGTH MAX	F MAX	GRIP MIN	GRIP MAX	LENGTH MIN	LENGTH MAX	F MAX	GRIP MIN	GRIP MAX	LENGTH MIN	LENGTH MAX	F MAX	GRIP MIN	GRIP MAX	LENGTH MIN	LENGTH MAX	F MAX	
01 (e)	.057	.078	.213	.342		.075	.100	.238	.418												
02	.063	.125	.260	.431		.080	.125	.263	.446		.100	.125	.287	.500							
03	.126	.187	.323	.516		.126	.187	.336	.541		.126	.187	.350	.571		.126	.187	.427	.637		
04	.188	.250	.385	.641		.188	.250	.398	.666		.188	.250	.412	.696		.188	.250	.460	.762		
05	.251	.312	.448	.766		.251	.312	.461	.791		.251	.312	.475	.821		.251	.312	.522	.887		
06	.313	.375	.510	.891		.313	.375	.523	.916		.313	.375	.537	.946		.313	.375	.585	1.012		
07	.376	.437	.573	1.016		.376	.437	.586	1.041		.376	.437	.600	1.071		.376	.437	.647	1.137		
08	.438	.500	.635	1.141		.438	.500	.648	1.166		.438	.500	.662	1.196		.438	.500	.710	1.262		
09	.501	.562	.698	1.266		.501	.562	.711	1.291		.501	.562	.725	1.321		.501	.562	.772	1.387		
10	.563	.625	.760	1.391		.563	.625	.773	1.416		.563	.625	.787	1.446		.563	.625	.835	1.512		
11						.626	.687	.836	1.541		.626	.687	.850	1.571		.626	.687	.897	1.637		
12											.688	.750	.912	1.696		.688	.750	.960	1.762		
13															.751	.812	1.022	1.887			
14															.813	.875	1.085	2.012			

* RIVET COMPOSITION LETTER DIMENSIONS IN INCHES

UNCONTROLLED COPY
WILL NOT BE KEPT UP TO DATE

REV.	DATE	BY	E.O. NO.	RIVET, BLIND - GENERAL PURPOSE, BULBED, 100° FLUSH HEAD, MECHANICALLY-LOCKED-SPINDLE, 5056 ALUMINUM, MONEL AND A-286 CRES RIVET SLEEVES	PREPARED	CHECKED	APPROVED
NC	11/06/08	P.M.	6581		PHILIP MCCURRIE	APPROVAL	
A	07/02/09	P.M.	6790		11/06/08	ON FILE	
B	08/09/11	P.M.	7410				
C	06/15/17	P.M.	9771	<p style="text-align: center;">ALLFAST</p> <p style="text-align: center;">15200 DON JULIAN ROAD . CITY OF INDUSTRY CA. 91745 PHONE: (626) 968-9388</p>	AF1921		
PROCUREMENT SPECIFICATION					PAGE 1 OF 2		
NAS1900							

TABLE III MATERIALS AND FINISHES

RIVET COMPONENTS	COMPOSITION B	COMPOSITION C	COMPOSITION M
MATERIALS			
SLEEVE	5056 (UNS A95056) ALUMINUM PER QQ-A-430	A286 CRES (UNS S66286) PER CHEMICAL REQUIREMENTS OF AMS5737	MONEL (UNS N04400) PER QQ-N-281
SPINDLE	2024 (UNS A92024) ALUMINUM PER QQ-A-430	A286 CRES (UNS S66286) PER CHEMICAL REQUIREMENTS OF AMS5737	A286 CRES (UNS S66286) PER CHEMICAL REQUIREMENTS OF AMS5737
LOCK RING	5056 (UNS A95056) ALUMINUM PER QQ-A-430	A286 CRES (UNS S66286) PER CHEMICAL REQUIREMENTS OF AMS5737 OR 316 CRES (UNS S31600) PER AMS5690	A286 CRES (UNS S66286) PER CHEMICAL REQUIREMENTS OF AMS5737, MONEL (UNS N04400) PER CHEMICAL REQUIREMENTS OF QQ-N-281 OR 316 CRES (UNS S31600) PER AMS5690
FINISHES			
SLEEVE	NONE OR CHEMICAL FILM TREAT PER MIL-C-5541 CL 1A	PASSIVATE PER QQ-P-35 OR CADMIUM PLATE PER QQ-P-416 TYPE II, CL 3 OR AL COATING PER NAS 4006	NONE OR CADMIUM PLATE PER QQ-P-416 TYPE II, CL 3 OR AL COATING PER NAS 4006
SPINDLE	CHEMICAL FILM TREAT PER MIL-C-5541 CL 1A	PASSIVATE PER QQ-P-35	PASSIVATE PER QQ-P-35
LOCK RING	NONE OR CHEMICAL FILM TREAT PER MIL-C-5541 CL 1A	PASSIVATE PER QQ-P-35	PASSIVATE PER QQ-P-35 FOR CRES ONLY

CODE: FIRST DASH NUMBER DESIGNATES DIAMETER IN .0312 INCREMENTS.
 SECOND DASH NUMBER DESIGNATES MAXIMUM GRIP IN .0625 INCREMENTS.
 ADD "A" AFTER SECOND DASH NUMBER FOR ALUMINUM COATING PER NAS 4006.
 ADD "B" AFTER BASIC NUMBER FOR COMPOSITION B ALUMINUM RIVET.
 ADD "C" AFTER BASIC NUMBER FOR COMPOSITION C A286 CRES RIVET.
 ADD "M" AFTER BASIC NUMBER FOR COMPOSITION M MONEL RIVET.
 ADD "P" AFTER SECOND DASH NUMBER TO DESIGNATE RIVET MAY BE SLOSH CLEANED WITH MIL-C-38736 CLEANER BEFORE INSTALLATION. RIVETS MAY BE LUBRICATED OR NON-LUBRICATED AT OPTION OF MANUFACTURER.
 ADD "S" AFTER FIRST DASH NUMBER TO DESIGNATE RIVET FOR USE WITH SINGLE ACTION (NON-SHIFTING) HAND HELD INSTALLATION TOOLS OR IN AUTOMATED INSTALLATION EQUIPMENT. SEE (f) SHEET 1.
 ADD "U" AFTER SECOND DASH NUMBER TO DESIGNATE RIVET UTILIZING DRIVE ANVIL WASHER AS PART OF RIVET ASSEMBLY. WASHER ALLOWS USE OF BLUNT NOSED INSTALLATION TOOLING. AVAILABLE WITH "S" CODE ONLY.
 ADD "W" AFTER SECOND DASH NUMBER FOR CADMIUM PLATED RIVET SLEEVE.
 ADD "FC" AFTER SECOND DASH NUMBER FOR COMPOSITION B RIVETS TO SPECIFY CHEMICAL FILM TREATMENT PER MIL-C-5541, CL 1A.

EXAMPLE OF PART NUMBER:

- AF1921B05S04 - 5056 ALUMINUM RIVET, .156 DIAMETER, .188 TO .250 GRIP RANGE, SINGLE ACTION, NO FINISH ON SLEEVE OR LOCK RING.
- AF1921B05S04FC - 5056 ALUMINUM RIVET, .156 DIAMETER, .188 TO .250 GRIP RANGE, SINGLE ACTION, CHEMICAL FILM TREAT ALL COMPONENTS PER MIL-C-5541, CL 1A.
- AF1921C05S04W - A286 CRES RIVET, .156 DIAMETER, .188 TO .250 GRIP RANGE, SINGLE ACTION, CADMIUM PLATED SLEEVE.
- AF1921M05S04P - MONEL RIVET, .156 DIAMETER, .188 TO .250 GRIP RANGE, REQUIRING SINGLE ACTION (NON-SHIFTING) INSTALLATION TOOLS, FOR SLOSH CLEANING IN MIL-C-38736 CLEANER (LUBRICATION OPTIONAL).
- AF1921M05S04U - MONEL RIVET, .156 DIAMETER, .188 TO .250 GRIP RANGE, WITH DRIVE ANVIL WASHER.

- NOTES: (1) THIS RIVET IS INTENDED FOR GENERAL PURPOSE USE IN BOTH THICK SHEET STACKUP AND IN THIN SHEET OR DOUBLE DIMPLD APPLICATIONS.
 (2) REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.
 (3) ADJUST HOLE SIZE WITHIN LIMITS OF TABLE I.

TABLE IV INSTALLED WEIGHTS

GRIP DASH NO.	INSTALLED WEIGHT (REF) POUNDS PER 1000 PIECES											
	AF1921*04 (.125 DIA)			AF1921*05 (.156 DIA)			AF1921*06 (.190 DIA)			AF1921*08 (.250 DIA)		
	AL B	A286 C	MONEL M	AL B	A286 C	MONEL M	AL B	A286 C	MONEL M	AL B	A286 C	MONEL M
01	.300	.890	.935	.510	1.457	1.512						
02	.355	1.033	1.086	.616	1.756	1.817	1.029	2.851	2.949			
03	.429	1.272	1.337	.744	2.126	2.205	1.218	3.373	3.497	2.495	7.208	8.039
04	.504	1.511	1.588	.871	2.496	2.593	1.408	3.895	4.045	2.820	8.147	9.087
05	.570	1.750	1.839	.999	2.866	2.981	1.597	4.417	4.593	3.145	9.085	10.134
06	.654	1.989	2.090	1.127	3.236	3.369	1.787	4.939	5.141	3.469	10.021	11.178
07	.738	2.228	2.341	1.255	3.606	3.757	1.976	5.461	5.689	3.793	10.958	12.222
08	.822	2.467	2.592	1.383	3.976	4.145	2.166	5.983	6.237	4.118	11.896	13.269
09	.906	2.706	2.843	1.511	4.346	4.533	2.355	6.505	6.785	4.442	12.803	14.313
10	.990	2.945	3.094	1.639	4.716	4.921	2.545	7.027	7.333	4.766	13.768	15.357
11				1.767	5.086	5.309	2.734	7.549	7.881	5.091	14.707	16.404
12							2.924	8.071	8.429	5.415	15.643	17.448
13										5.739	16.580	18.492
14										6.064	17.518	19.540

- (a) * RIVET COMPOSITION CODE LETTER.
 (b) REFERENCE WEIGHTS ARE FOR DESIGN PURPOSE ONLY.

**UNCONTROLLED COPY
WILL NOT BE KEPT UP TO DATE**

REV.	DATE	BY	E.O. NO.	RIVET, BLIND - GENERAL PURPOSE, BULBED, 100° FLUSH HEAD, MECHANICALLY-LOCKED-SPINDLE, 5056 ALUMINUM, MONEL AND A-286 CRES RIVET SLEEVES	PREPARED	CHECKED	APPROVED
NC	11/06/08	P.M.	6581		PHILIP MCCURRIE	APPROVAL ON FILE	
A	07/02/09	P.M.	6790		11/06/08		
B	08/09/11	P.M.	7410				
C	06/15/17	P.M.	9771				
PROCUREMENT SPECIFICATION				ALLFAST 15200 DON JULIAN ROAD . CITY OF INDUSTRY CA. 91745 PHONE: (626) 968-9388	AF1921		
NAS1900					PAGE 2 OF 2		