



TABLE I

DIAMETER DASH NUMBER	RIVET SIZE NOMINAL	A DIA.(c) +.0035 - .0010	B DIAMETER	C +.010 - .000	G MINIMUM	HOLE LIMIT +.0000 - .0020
-04	.125	.125	.250±.012	.054	.788	.1320
-05	.156	.156	.312±.016	.067	.788	.1640
-06	.190	.187	.375±.019	.080	.788	.1960
-08	.250	.250	.500±.025	.107	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) "A" DIAMETER MAY BE .001 SMALLER BEYOND MINIMUM GRIP LENGTH.
- (e) GRIP SYMBOL FOR -00 SHALL BE GREEK LETTER THETA "θ".
- (f) 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.
- (g) 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.	AF1919*04 (.125 DIA)				AF1919*05 (.156 DIA)				AF1919*06 (.190 DIA)				AF1919*08 (.250 DIA)			
	GRIP MIN	GRIP MAX	LENGTH MAX	F MAX	GRIP MIN	GRIP MAX	LENGTH MAX	F MAX	GRIP MIN	GRIP MAX	LENGTH MAX	F MAX	GRIP MIN	GRIP MAX	LENGTH MAX	F MAX
00	.020	.035	.171	.298	.025	.045	.193	.356								
01	.025	.062	.198	.338	.031	.062	.227	.378	.037	.062	.251	.431				
02	.063	.125	.260	.443	.063	.125	.273	.478	.063	.125	.287	.526	.063	.125	.335	.606
03	.126	.187	.323	.568	.126	.187	.336	.602	.126	.187	.350	.651	.126	.187	.397	.731
04	.188	.250	.385	.693	.188	.250	.398	.727	.188	.250	.412	.776	.188	.250	.460	.856
05	.251	.312	.448	.818	.251	.312	.461	.852	.251	.312	.475	.901	.251	.312	.522	.981
06	.313	.375	.510	.943	.313	.375	.523	.977	.313	.375	.537	1.026	.313	.375	.585	1.106
07	.376	.437	.573	1.068	.376	.437	.586	1.102	.376	.437	.600	1.151	.376	.437	.647	1.231
08	.438	.500	.635	1.193	.438	.500	.648	1.227	.438	.500	.662	1.276	.438	.500	.710	1.356
09	.501	.562	.698	1.318	.501	.562	.711	1.352	.501	.562	.725	1.401	.501	.562	.772	1.481
10	.563	.625	.761	1.443	.563	.625	.773	1.477	.563	.625	.787	1.526	.563	.625	.835	1.606
11					.626	.687	.836	1.602	.626	.687	.850	1.651	.626	.687	.897	1.731
12									.688	.750	.912	1.776	.688	.750	.960	1.856
13													.751	.812	1.022	1.981
14													.813	.875	1.085	2.106

* RIVET COMPOSITION LETTER DIMENSIONS IN INCHES

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REV.	DATE	BY	E.O. NO.	RIVET, BLIND - GENERAL PURPOSE, BULBED, PROTRUDING HEAD, MECHANICALLY-LOCKED-SPINDLE, 5056 ALUMINUM, MONEL AND A-286 CRES RIVET SLEEVES	PREPARED	CHECKED	APPROVED
NC	11/06/08	P.M.	6580		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				
PROCUREMENT SPECIFICATION				ALLFAST 15200 DON JULIAN ROAD . CITY OF INDUSTRY CA. 91745 PHONE: (626) 968-9388	AF1919		
NAS1900					PAGE 1 OF 2		

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:

- AF1919B05S04 - 5056 ALUMINUM RIVET, .156 DIAMETER, .188 TO .250 GRIP RANGE, SINGLE ACTION, NO FINISH ON SLEEVE OR LOCK RING.
- AF1919B05S04FC - 5056 ALUMINUM RIVET, .156 DIAMETER, .188 TO .250 GRIP RANGE, SINGLE ACTION, CHEMICAL FILM TREAT ALL COMPONENTS PER MIL-C-5541, CL 1A.
- AF1919C05S04W - A286 CRES RIVET, .156 DIAMETER, .188 TO .250 GRIP RANGE, SINGLE ACTION, CADMIUM PLATED SLEEVE.
- AF1919M05S04P - 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).
- AF1919M05S04U - 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 DIMPLED 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											
	AF1919*04 (.125 DIA)			AF1919*05 (.156 DIA)			AF1919*06 (.190 DIA)			AF1919*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
00	.314	1.080	1.205	.763	2.204	2.270						
01	.424	1.294	1.308	.782	2.361	2.431	1.300	3.833	4.288			
02	.505	1.533	1.559	.896	2.731	2.819	1.482	4.355	4.836	3.196	9.233	10.293
03	.585	1.772	1.810	1.010	3.101	3.207	1.664	4.877	5.384	3.520	10.168	11.342
04	.666	2.011	2.061	1.124	3.471	3.595	1.846	5.399	5.932	3.844	11.105	12.386
05	.746	2.250	2.312	1.238	3.841	3.983	2.028	5.921	6.480	4.169	12.043	13.433
06	.827	2.489	2.563	1.352	4.211	4.371	2.210	6.443	7.028	4.493	12.980	14.477
07	.907	2.728	2.814	1.466	4.581	4.759	2.392	6.965	7.576	4.817	13.916	15.521
08	.988	2.967	3.065	1.580	4.951	5.147	2.574	7.487	8.124	5.142	14.855	16.569
09	1.068	3.206	3.316	1.694	5.321	5.535	2.756	8.009	8.672	5.466	15.791	17.612
10	1.149	3.445	3.567	1.808	5.691	5.923	2.938	8.531	9.220	5.791	16.729	18.660
11				1.922	6.061	6.311	3.120	9.053	9.768	6.115	17.665	19.704
12							3.302	9.575	10.316	6.439	18.601	20.743
13										6.764	19.540	21.795
14										7.088	20.476	22.839

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

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