

MS14218 REV C 53 ■ 9999912 0003880 2 ■

D1505

FED. SUP CLASS
5320

USER SYMBOLS:

REVIEWER SYMBOLS:

ARMY - AR
AIR FORCE - 99
DLA - 15

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1. APPLICATION

1.1 THESE RIVETS ARE INTENDED FOR USE IN RIVETED STRUCTURES WHERE FLUSHNESS, FATIGUE LIFE, STATIC JOINT STRENGTH AND CORROSION RESISTANCE ARE OF PRIMARY DESIGN IMPORTANCE.

1.2 RIVETS SHALL BE USED IN ACCORDANCE WITH MIL-STD-1515, REQUIREMENT 206.

2. MILITARY INSTALLATION MANUAL: MIL-HDBK-271-102

3. MATERIALS

3.1 ALUMINUM ALLOYS PER QQ-A-430 MATERIAL LETTER CODE

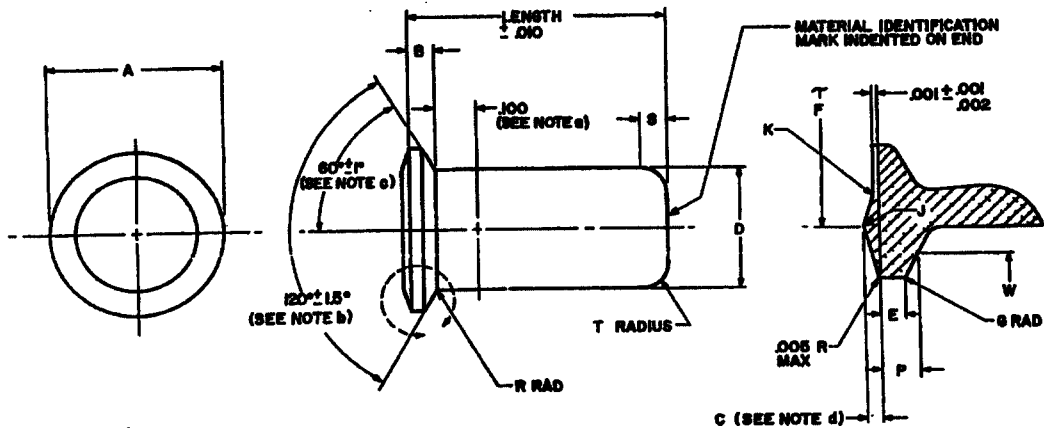
- 3.1.1 2017-T4 D
- 3.1.2 2117-T4 AD
- 3.1.3 5056-H32 B
- 3.1.4 7050-T73 E
- 3.1.5 TITANIUM COLUMBIUM, 45 cb PER AMS 4982. T

3.2 COATINGS, ALUMINUM ALLOYS.

- (C) 3.2.1 ANODIZED PER MIL-A-8625, TYPE II, CLASS 1, DICHROMATE SEAL AT 208° TO 212° F.
- 3.2.2 CHEMICAL SURFACE TREATMENT PER MIL-C-5541, CLASS 1A. C

4. HEAT TREATMENT: IN ACCORDANCE WITH MIL-H-6088 FOR ALUMINUM ALLOYS. IN ACCORDANCE WITH AMS 4982 FOR TITANIUM COLUMBIUM ALLOYS.

5. ILLUSTRATION



- (a) .001 SHANK DIAMETER INCREASE PERMISSIBLE WITHIN .100-INCH OF HEAD.
- (b) THE 120° CONICAL SURFACE OF THE HEAD SHALL BE ANGULAR WITHIN .002 AND CONCENTRIC WITH THE SHANK OF THE RIVET WITHIN .003 TOTAL INDICATOR READING.
- (c) HEAD COCKING ANGLE RELATIVE TO AXIS OF RIVET 1° MAXIMUM.
- (d) THE RIVET CROWN (C DIMENSION) SHALL JOIN THE RIVET HEAD FLAT SURFACE SMOOTHLY WITHOUT ABRUPT SHOULDERS.

(C) DENOTES CHANGES

NAVY - AS Other Code ARMY - AV AIR FORCE - 11 PROCUREMENT SPECIFICATION MIL-R-5674	TITLE	MILITARY STANDARD
	RIVET, SOLID, 120° FLUSH INTERFERENCE SHEAR HEAD	MS14218
SUPRESEDES:	SHEET 1 OF 3	

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PLATE NO. 17709
PROJECT NO. 5320-0576

APPROVED 4 AUGUST 1982 REVISED (A) 15 MAY 1984 (B) 8 AUG 1984 (C) 25 JAN 85

PROBLEM HARD COPY

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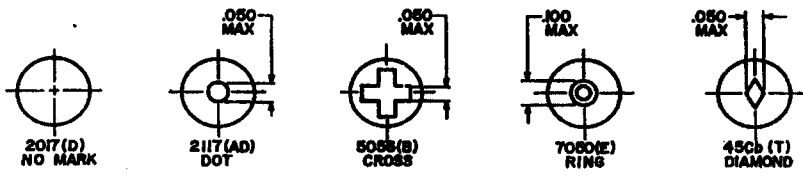
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 DIA - IS

5.1 MATERIAL IDENTIFICATION SYMBOLS. SYMBOLS INDENTED .030 MAXIMUM DEPTH.



6. TABLE I. RIVET DIMENSIONS

DIA DASH NO.	NOM DIA	A +.000 -.002	B (REF)	C	D +.002 -.001	E MIN	F +.010	G RAD MAX	J RAD +.010	K RAD MIN	P		R RAD +.004	S +.010	T RAD +.010	W	
											MAX	MIN				GAGE	DIA MAX MIN
-3	3/32	.123	.022	.004 .008	.094	.012	.094	.005	.016	.031	.0188	.0167	.008	.023	.029	.1102	.1100
-4	1/8	.162	.027	.004 .008	.125	.014	.125	.005	.016	.047	.0223	.0202	.011	.031	.039	.1462	.1460
-5	5/32	.210	.035	.005 .009	.156	.017	.156	.005	.020	.060	.0270	.0248	.014	.039	.049	.1892	.1890
-6	3/16	.258	.044	.005 .009	.187	.021	.188	.006	.025	.078	.0289	.0266	.018	.047	.059	.2422	.2420
-7	7/32	.312	.053	.006 .010	.222	.024	.219	.007	.025	.094	.0411	.0387	.022	.054	.069	.2671	.2669
-8	1/4	.358	.061	.006 .011	.250	.027	.250	.009	.031	.125	.0470	.0444	.026	.062	.078	.3038	.3036
-9	9/32	.405	.069	.007 .012	.283	.030	.281	.010	.040	.125	.0539	.0531	.029	.068	.090	.3315	.3313
-10	5/16	.454	.077	.007 .012	.310	.033	.313	.010	.040	.125	.0465	.0435	.031	.078	.098	.4245	.4243

7. TABLE II. RIVET MECHANICAL PROPERTIES

ALLOY AND TEMPER	TENSILE STRENGTH psi MIN	YIELD STRENGTH psi MIN	ELONGATION IN 2 INCHES OR 4D % MIN	UNDRIVEN SHEAR STRENGTH psi	
				MIN	MAX
5056-H32	44,000	-----	-----	24,000	-----
2117-T4	38,000	18,000	18	26,000	-----
2017-T4	55,000	32,000	12	33,000	39,000
7050-T73	68,000	58,000	10	41,000	46,000
45 Cb	65,000	60,000	15	50,000	56,000

8. TABLE III. LENGTH NUMBERS

LENGTH (a)	DIAMETER DASH NUMBERS							
	-3	-4	-5	-6	-7	-8	-9	-10
.125	2	-	-	-	-	-	-	-
.156	2R	-	-	-	-	-	-	-
.188	3	-	-	-	-	-	-	-
.219	3R	3R	3R	-	-	-	-	-
.250	4	4	4	4	-	-	-	-
.281	4R	4R	4R	4R	-	-	-	-
.312	5	5	5	5	5	-	-	-
.343	5R	5R	5R	5R	5R	5R	-	-
.375	6	6	6	6	6	6	6	-
.406	6R	6R	6R	6R	6R	6R	6R	-
.438	7	7	7	7	7	7	7	7
.470	7R	7R	7R	7R	7R	7R	7R	7R
.500	8	8	8	8	8	8	8	8
.531	8R	8R	8R	8R	8R	8R	8R	8R

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P.A. NAVY - AS Other Code ARMY - AV AIR FORCE - 11 PROCUREMENT SPECIFICATION MIL-R-3674	TITLE	MILITARY STANDARD MS14218 SHEET 2 OF 3
	RIVET, SOLID, 120° FLUSH INTERFERENCE SHEAR HEAD SUPERSEDES:	

DD FORM 672-1 (Coordinated)

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PLATE NO. 17709

APPROVED 4 AUGUST 1982 REVISED (C) FOR CHANGES SEE SHEETS 1 AND 2

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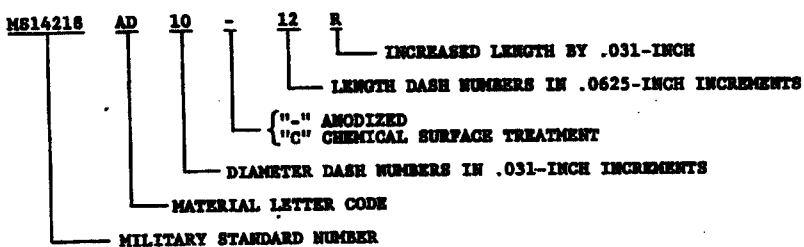
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LENGTH (a)	DIAMETER DASH NUMBERS								
	-3	-4	-5	-6	-7	-8	-9	-10	
.562	9	9	9	9	9	9	9	9	
.593	9R	9R	9R	9R	9R	9R	9R	9R	
.625	10	10	10	10	10	10	10	10	
.687	11	11	11	11	11	11	11	11	
.750	12	12	12	12	12	12	12	12	
.812	-	13	13	13	13	13	13	13	
.875	-	14	14	14	14	14	14	14	
.937	-	15	15	15	15	15	15	15	
1.000	-	16	16	16	16	16	16	16	
1.062	-	-	17	17	17	17	17	17	
1.125	-	-	18	18	18	18	18	18	
1.187	-	-	19	19	19	19	19	19	
1.250	-	-	20	20	20	20	20	20	
1.312	-	-	21	21	21	21	21	21	
1.375	-	-	22	22	22	22	22	22	
1.437	-	-	23	23	23	23	23	23	
1.500	-	-	24	24	24	24	24	24	
1.625	-	-	25	25	25	25	25	25	
1.750	-	-	26	26	26	26	26	26	
1.875	-	-	28	28	28	28	28	28	
2.000	-	-	-	-	-	30	30	30	
	-	-	-	-	-	32	32	32	

(a) RIVET BODY SHALL HAVE A RADIUS END EXCEPT THAT LENGTH IN SHADED AREA MAY HAVE A SQUARED END. REVISED ALL LENGTHS TO 0.0625 INCREMENTS; R DESIGNATES 0.031 INCREASED LENGTHS.

9. EXAMPLE OF PART NUMBER:



- 10. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
- 11. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BIDS OR REQUEST FOR PROPOSAL EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.
- 12. THE RIVETS ARE A PROPRIETARY PRODUCT OF BRILES RIVET CORPORATION AND ARE COVERED BY PATENT NO. 4,157,666 EXPIRING 3 JULY 1996. THE UNITED STATES GOVERNMENT DOES NOT HAVE A ROYALTY-FREE LICENSE.

APPROVED 4 AUGUST 1982 REVISED (C) FOR CHANGES SEE SHEETS 1 AND 2

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	RIVET, SOLID, 120° FLUSH INTERFERENCE SHEAR HEAD	MS14218
PROCUREMENT SPECIFICATION MIL-R-5674	SUPERSEDES:	SHEET 3 OF 3

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