

## BOEING ADDED INFORMATION (See NAS1398SUP)

BOEING DATE REV (11) 21-MAR-2001

BCAG

BD&amp;SG

BH

NEW DESIGN APPROVAL: P = PARTIAL; F = FULL; N = NONE

P

F

P



**Aerospace  
Industries  
Association**

## NATIONAL AEROSPACE STANDARD

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SUBDIRECCION DE INGENIERIA  
FACTORIA DE C I PABLO

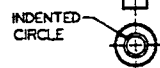
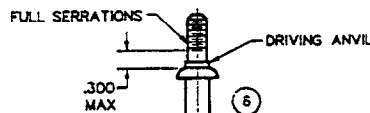


HEAD MARKINGS (TO BECOME EFFECTIVE 1 JUNE 1963)  
-4 AND LARGER ONLY.

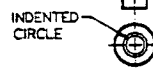
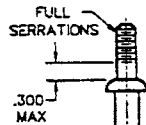
MATERIAL CODE - M FOR MONEL, C FOR A-286  
NO LETTER FOR ALUMINUM

GRIP NUMBER OPTIONAL FOR ALL MATERIALS

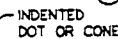
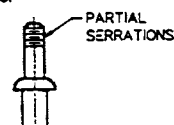
MANUFACTURER'S IDENTIFICATION  
MANDATORY FOR RIVETS RECEIVED  
AFTER 1 JULY 1971 (NOT REQUIRED ON -3 DIA)



CODE "AB" IN  
PART NO.



CODE "A" IN  
PART NO.



NO CODE IN  
PART NO.

SPINDLE CONFIGURATION IDENTIFICATION

- 6 INTERCHANGEABILITY: THE "A" AND "AB" CODE RIVETS (FULL SERRATIONS) AND NO CODE RIVETS (PARTIAL SERRATIONS) ARE PHYSICALLY AND FUNCTIONALLY INTERCHANGEABLE EXCEPT FOR INSTALLATION TOOLS (PULLING HEADS).

CODES -

- ADD LETTER B AFTER BASIC PART NUMBER TO INDICATE 5056 ALUMINUM ALLOY SLEEVE  
ADD LETTER D AFTER BASIC PART NUMBER TO INDICATE 2017 ALUMINUM ALLOY SLEEVE  
ADD LETTER M AFTER BASIC PART NUMBER TO INDICATE MONEL SLEEVE  
ADD LETTER C AFTER BASIC PART NUMBER TO INDICATE A-286 CORROSION RESISTANT STEEL SLEEVE  
ADD LETTER FC AFTER MATERIAL CODE LETTER TO INDICATE CHEMICAL FILM TREATMENT PER MIL-C-5541  
ADD LETTER P AFTER MATERIAL CODE LETTER TO INDICATE ANODIZE PER MIL-A-8625  
ADD LETTER W AFTER MATERIAL CODE LETTER TO INDICATE CADMIUM PLATED SLEEVE  
ADD LETTER S AFTER MATERIAL CODE LETTER TO INDICATE SILVER PLATED SLEEVE  
ADD LETTER A IN PLACE OF (-) BETWEEN DIAMETER AND GRIP TO INDICATE RIVET WITH FULL SERRATED STEM  
6 ADD LETTER AB IN PLACE OF (-) BETWEEN DIAMETER AND GRIP TO INDICATE RIVET WITH FULL SERRATED STEM AND DRIVING ANVIL

EXAMPLE OF PART NUMBERS:

- NAS1398M4-4 = NICKEL-COPPER-ALLOY (MONEL) RIVET, .125 DIA. WITH .188 TO .250 GRIP RANGE WITH NO FINISH ON SLEEVE, WITH PARTIAL SERRATED STEM AND INDENTED DOT OR CONE IDENTIFICATION.  
NAS1398B4-4 = 5056 ALUMINUM-ALLOY RIVET, .125 DIA WITH .188 TO .250 GRIP RANGE, WITH PARTIAL SERRATED STEM AND INDENTED DOT OR CONE IDENTIFICATION. FINISH OPTIONAL - CHEMICAL FILM OR ANODIZE, ORANGE COLORED SLEEVE.  
NAS1398MW4A4 = NICKEL-COPPER-ALLOY (MONEL) RIVET, .125 DIA WITH .188 TO .250 GRIP RANGE CADMIUM PLATED, WITH FULL SERRATED STEM AND INDENTED CIRCLE IDENTIFICATION  
6 NAS1398D4AB4 = 2017 ALUMINUM-ALLOY RIVET, .125 DIA WITH .188 TO .250 GRIP RANGE, WITH DRIVING ANVIL, FULL SERRATED STEM AND INDENTED CIRCLE IDENTIFICATION. FINISH OPTIONAL - CHEMICAL FILM OR ANODIZE.  
NAS1398BFC4-4 = 5056 ALUMINUM-ALLOY RIVET, .125 DIA WITH .188 TO .250 GRIP RANGE, WITH PARTIAL SERRATED STEM AND INDENTED DOT OR CONE IDENTIFICATION. FINISH - CHEMICAL FILM PER MIL-C-5541

INDEX OF CURRENT SHEETS	
SHEET NO.	REV. NO.
1	6
2	5

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT  
SPECIFICATION

NAS1400

TITLE

RIVET-BLIND, PROTRUDING HEAD,  
LOCKED SPINDLE

THIRD  
ANGLE  
PROJECTION

CLASSIFICATION

NAS 1398

Sheet 1 of 2

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NAS1398

**BOEING PART STANDARD**

PAGE 80.71.5.1.1.1

SHEET 1 OF 2

NAS1398

PAGE 80.71.5.1.1.1

REVISION 6 14 AUG 1985

APRIL 1981

APPROVAL DATE



Aerospace  
Industries  
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MATERIAL, FINISH, AND COLOR							
BASIC PART NO.	MATERIAL			FINISH			COLOR
	SLEEVE	STEM	LOCK RING (C)	SLEEVE	STEM	LOCK RING (C)	SLEEVE
NAS1398B	5056-F QQ-A-430 (UNS A95056)	7075 QQ-A-430 (UNS A97075)	5056-H38 QQ-A-430 (UNS A95056)	ANODIZE PER MIL-A-8625 WHEN SPECIFIED BY CODE LETTER (P) OR CHEMICAL SURFACE TREAT PER MIL-C-5541 WHEN SPECIFIED BY CODE LETTER (FC)	ANODIZE PER MIL-A-8625 WHEN SPECIFIED BY CODE LETTER (P) OR CHEMICAL SURFACE TREAT PER MIL-C-5541 WHEN SPECIFIED BY CODE LETTER (FC)	NONE	ORANGE SIMILAR TO FED. STD. NO. 595 COLOR NO. 32246
NAS1398D	2017-T4 QQ-A-430 (UNS A92017)						
NAS1398M	MONEL QQ-N-281 (UNS N04400)	MONEL QQ-N-281 (UNS N04400) OR A-286 AMS 5731 OR AMS 5732 (UNS S66286)	MONEL QQ-N-281 (UNS N04400)	CAD PLATE PER QQ-P-416 TYPE II CLASS 2 WHEN SPECIFIED BY CODE LETTER (W) OR SILVER PLATE PER QQ-S-365 .0002 MIN. THICK. WHEN SPECIFIED BY CODE LETTER (S)	NONE	NONE	NATURAL (AS PLATED AND/OR LUBRICATED)
NAS1398C	A-286 AMS 5731 AMS 5732 OR AMS 5737 (UNS S66286)	A-286 AMS 5731 (UNS S66286)	MONEL QQ-N-281 (UNS N04400)				

(c) THE MATERIAL AND FINISH LISTED ARE FOR RIVETS WITH PARTIAL SERRATED STEMS ONLY. FOR THE FULLY  
SERRATED STEM SERIES THE LOCK RING MAY BE INTEGRAL WITH THE SLEEVE, IN WHICH CASE THE LOCK RING  
IS OF THE SAME MATERIAL AND FINISH AS THE SLEEVE.

GRIP DASH NO.	NAS1398( )3 .094 DIA				NAS1398( )4 .125 DIA				NAS1398( )5 .156 DIA				NAS1398( )6 .190 DIA				NAS1398( )8 .250 DIA			
	LENGTH	GRIP	RANGE	F	LENGTH	GRIP	RANGE	F	LENGTH	GRIP	RANGE	F	LENGTH	GRIP	RANGE	F	LENGTH	GRIP	RANGE	F
-1	.193	.020	.062	.33	.196	.025	.062	.39	.201	.031	.062	.38	.225	.037	.062	.44				
-2	.229	.063	.125	.43	.250	.063	.125	.51	.263	.063	.125	.49	.287	.063	.125	.55	.323	.063	.125	.57
-3	.291	.126	.187	.53	.323	.126	.187	.63	.326	.126	.187	.61	.350	.126	.187	.67	.385	.126	.187	.69
-4	.354	.188	.250	.63	.385	.188	.250	.75	.388	.188	.250	.73	.412	.188	.250	.79	.448	.188	.250	.81
-5					.448	.251	.312	.87	.451	.251	.312	.85	.475	.251	.312	.91	.510	.251	.312	.93
-6					.510	.313	.375	.98	.513	.313	.375	.97	.537	.313	.375	1.03	.573	.313	.375	1.04
-7									.576	.376	.437	1.09	.600	.376	.437	1.15	.635	.376	.437	1.16
-8									.638	.438	.500	1.20	.662	.438	.500	1.27	.698	.438	.500	1.28
-9									.701	.501	.562	1.38	.725	.501	.562	1.44	.760	.501	.562	1.46
-10									.763	.563	.625	1.50	.787	.563	.625	1.56	.823	.563	.625	1.58
-11													.850	.626	.687	1.68	.885	.626	.687	1.70
-12													.912	.688	.750	1.81	.948	.688	.750	1.83
-13																	1.010	.751	.812	1.95
-14																	1.073	.813	.875	2.07

NOTE: SIZES BELOW HEAVY LINE AVAILABLE IN TYPE M AND C MATERIALS ONLY

-CAUTION- RIVETS WITH DIFFERENT SPINDLE CONFIGURATIONS CANNOT BE INSTALLED WITH THE SAME TOOL (PULLING HEAD);  
SEE PARAGRAPH 6.3 OF NAS1400.

(5) COMPLETELY REVISED

NAS 1398

Sheet 2

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