

MCDONNELL DOUGLAS

SAINT LOUIS, MISSOURI

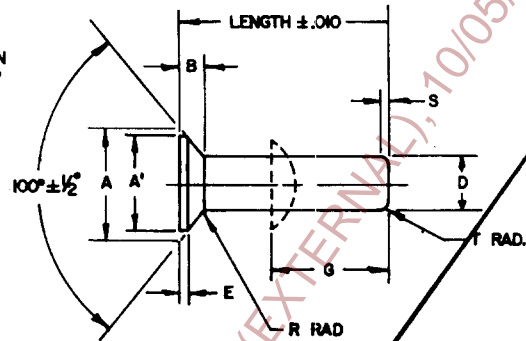
STANDARDFED SUP CLASS
5320BASIC CODE: ANE
ST3M718-()-()MANUFACTURERS
IDENT.
'O' = SCREW CORP.
'T' = CHERRY RIVETINDENTED MATERIAL IDENTIFICATION
MARK ON RIVET HEAD, .030 X .030

TABLE I

APPROVED CALLOUT	A ±.004	B REF	D +.003 -.001	E MAX	A' MIN	G MIN	R RAD ±.001	S +.010	T RAD ±.005
ST3M718-3-()	.179	.036	.094	.006	.165	.094	.010	.023	.029
-4-()	.125	.042	.125	.008	.207	.125	.015	.031	.039
-5-()	.286	.055	.156	.010	.263	.156	.020	.039	.049
ST3M718-6-()	.353	.070	.187	.010	.330	.187	.025	.047	.059

TABLE II

FIRST DASH NO.	LENGTHS AND SECOND DASH NO.														
	.1875	.250	.3125	.375	.4375	.500	.5625	.625	.750	.875	1.000	1.125	1.250	1.375	1.500
-3	3	4	5	6	7	8	9	10	12	14	16	18	20	22	24
-4	3	4	5	6	7	8	9	10	12	14	16	18	20	22	24
-5		4	5	6	7	8	9	10	12	14	16	18	20	22	24
-6			5	6	7	8	9	10	12	14	16	18	20	22	24

TABLE III

DIA	MIN. UNDRIVEN DOUBLE SHEAR STRENGTH LBS	MIN. DRIVEN SINGLE SHEAR STRENGTH LBS
.094	80	30
.125	210	648
.156	1900	993
.187	2720	1430

E

INACTIVE FOR
NEW DESIGN AND
PROCUREMENT
AFTER OCT 1984
SUPERSEDED BY
MS20426T

DIMENSIONS IN INCHES: TOLERANCES UNLESS OTHERWISE SPECIFIED: .XX ± .03; .XXX ± .010; ANGLES ± 1/2°

CUSTODIAN: MCAIR

PROCUREMENT
SPECIFICATION23M120 [2]
TYPE (d)

TITLE

RIVET, SOLID-100° C'SUNK, MS20426 HEAD CONFIGURATION,
Ti-Cb MATERIALCLASSIFICATION
STANDARD PART DOCUMENT**ST3M718**

SHEET 1 OF 2

MCDONNELL DOUGLAS
SAINT LOUIS, MISSOURI
STANDARD

ENGINEERING INFORMATION:

1. THIS RIVET IS INTENDED FOR USE WHERE ST3M718 WILL NOT MEET DESIGN REQUIREMENTS.
2. INTERMEDIATE LENGTHS MAY BE SPECIFIED IN 16TH INCH INCREMENTS BY USE OF SIGNIFICANT DASH NUMBERS.
3. RIVETS LONGER THAN -24 SHALL NOT BE SPECIFIED.

EXAMPLE OF APPROVED CALLOUT:

ST3M718 -4 -12 RIVET
LENGTH IN 16THS
DIAMETER IN 32NDS

MATERIAL:

55T1-45C6 PER AMS4982

FINISH:

NONE

NOTES:

1. THESE PARTS SHALL BE SPECIFIED, PROCURED AND USED UNDER THE APPROVED CALLOUT NUMBER.
2. PROCUREMENT SPECIFICATION: TYPE (D).
3. THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
4. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.
5. ALL INTERIOR PACKAGES SHALL BE MARKED PER MIL-STD-129. INTERIOR PACKAGES SHALL ALSO BE DURABLY MARKED WITH THE COMPLETE MCDONNELL APPROVED CALLOUT NUMBER.
6. .001 SHANK DIA. INCREASE PERMISSIBLE WITHIN .100 INCH OF BASE OF HEAD.
7. A PROFILE VIEW OF LAND AREA MAY VARY FROM A LINE PARALLEL WITH THE SHANK TO CURVE THAT WILL FALL WITHIN THE LIMITS ALLOWED.
8. THE CONICAL SURFACE OF THE HEAD SHALL BE CONCENTRIC WITH THE SHANK OF THE RIVET WITHIN .005 (.010 FULL INDICATOR READING.)
9. HEAD COCKING ANGLE RELATIVE TO AXIS OF RIVET 1/2° MAX.
10. MAXIMUM HEAD DIAMETERS ARE TO THEORETICAL SHARP CORNERS AS MEASURED BY PROJECTION.

INFORMATION BELOW THIS LINE NOT PERTINENT TO ENGINEERING DESIGN

APPROVED CALLOUT	APPROVED VENDOR AND VENDOR'S DESIGNATION ▲		SUPRESEDED PARTS NOT APPROVED FOR PROCUREMENT FOR DISPOSITION DIRECTIONS (SEE 6M148)
ST3M718-3- -4- -5- ST3M718-6- -4- -5- -6-	CSR902B-3- -4- -5- CSR902B-6- -4- -5- -6-	SC-R31-3- -4- -5- SC-R31-6- -4- -5- -6-	NONE NONE

PROCUREMENT REQUIREMENTS:

ST3M718 (REV E)

RECEIVING INSPECTION REQUIREMENTS:

▲ APPROVED VENDOR'S NAME AND FSCM NO.:

CSR902B SERIES: CHERRY FASTENERS, TOWNSEND DIV., SANTA ANA, CA (11815)
SC-R31 SERIES: VSI SCREW CORP. DIV., CITY OF INDUSTRY, CALIF (06950)

- NOTES: 1. FOR SHOP AND PROCUREMENT USE ONLY. ADDITIONAL 1/32" LENGTH INCREMENTS MAY BE OBTAINED BY ADDING -5 AFTER LETTER FOLLOWING LAST DASH NUMBERS.

ST3M718

SHEET 2

REVISION (A) MAY 77 (B) MAR 78 (C) MAY 78 (D) JUN 82 (E) OCT 84

APPROVAL DATE FEBRUARY 1976

CODE IDENT : 6301