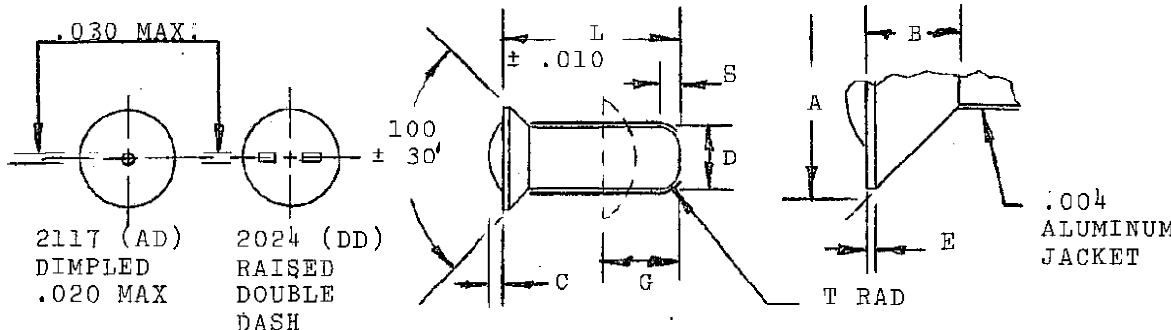


DE HAVILLAND AIRCRAFT of CANADA

PAGE

STANDARDS SHEET



NOM DIA	A	B	C +.002 -.000	D +.002 -.001	E	G	S ±.010	T ±.010
.125	.1957 .1884	.0286	.003	.125	.006 .003	.188	.031	.039
.156	.2469 .2396	.0372	.003	.156	.006 .003	.234	.039	.049
.188	.3016 .2966	.046	.003	.187	.006 .003	.281	.047	.059
.250	.3948 .3898	.060	.003	.250	.006 .003	.375	.062	.078

MATERIAL: Rivet - Aluminum alloy 2024-T4 (DD) or 2117-T4 (AD) to Procurement Spec. MIL-R-5674.
Jacket - Aluminum alloy 1100 or 6061 Cond. "0"

FINISH: Alodine Rivet to MIL-C-5541, Class 3. No finish on jacket.

- NOTES:**
- Without Jacket rivet dimensions are the same as NAS 1097.
 - Alum Jacket is .004 wall thickness.
 - Engineering shall specify complete part number (dia & length) and quantity (best approximation) on drawing.
 - Rivet code is "XK" for AD Rivet and "XL" for DD Rivet.

EXAMPLE: CSP372 ADJ4-5-8 is 2117-T4 Rivet with .004 Jacket .156 Dia and .500 Long (Length is Grip + 1 1/2 Dia).

Add'l Note: 5. It is good practice to have grip lengths not more than 4X rivet diameter.

DRAWN	KROMKAMP	CLASSIFICATION	STANDARD
CHECKED	SCARFOLD	RIVET, SOLID, WITH JACKET, NAS 1097 HEAD, ALUMINUM ALLOY	CSP 372
STRESSED	1/2		
APPROVED	1/2		

SIDS NCP 26 AUG 68

NOTE 5. ADDED 8/4/85 RS RR

CLASS 3 ADDED TO ALODINE FINISH 15-2-82 JF MS