Form Approved
OMB No 0704-0188

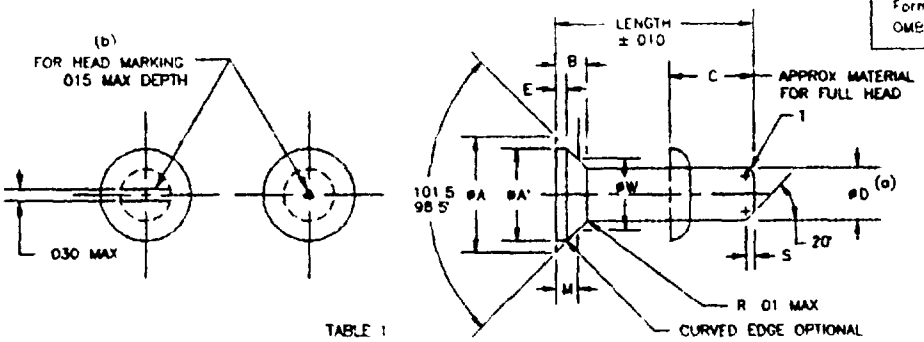

TABLE I

NOM. DIA	øA MAX	øA MIN	B MAX	C	øD MAX	øD MIN	E MAX	M MAX	M MIN	ø W MAX	ø W MIN	S MAX	T RAD MAX
1/16	1346	0898	0317	094	065	061		0165	0105	0842	0840	016	019
3/32	1900	1548	0418	140	097	093	008	0179	0118	1462	1460	023	029
1/8	2360	2006	0483	187	128	124		0191	0130	1892	1890	031	038
5/32	2976	2566	0614	234	159	155	010	0226	0163	2422	2420	039	049
3/16	3654	3234	0769	281	190	186		0252	0185	3036	3036	047	059
1/4	4890	4412	1034	375	253	249		0289	0220	4182	4180	062	078
5/16	5772	5288	1147	469	315	311	012	0315	0245	5000	4998	078	098
3/8	7074	6586	1436	562	378	374		0341	0270	6240	6238	094	117

(a) SHANK DIAMETER TO BE MEASURED WITHIN 10 INCH OF BASE HEAD
(b) RECESSED TRIANGLE FOR MILD STEEL RIVETS ONLY RECESSED DASH FOR CORROSION-RESISTANT STEEL RIVETS ONLY NO HEAD MARKING REQUIREMENT FOR COPPER OR MONEL RIVETS
(c) THE CONICAL SURFACE OF THE HEAD SHALL BE CONCENTRIC WITH THE SHANK OF THE RIVET WITHIN 005 TOTAL RUNOUT
(d) HEAD COCKING ANGLE RELATIVE TO AXIS OF RIVET 1/2° MAXIMUM
(e) RIVETS MAY BE FURNISHED WITH PLAIN ENDS, OR A RADIUS TO T DIMENSION OR A 20° CHAMFER TO S DIMENSION

REQUIREMENTS.

1 MATERIAL. CARBON STEEL, FED STD 66, C1010-C1015 ANNEALED AFTER HEADING.
CORROSION-RESISTANT STEEL, FED STD 66, 300 SERIES, CONDITION A, ANNEALED AFTER HEADING BY HEATING AT 1 950 TO 2,000°F FOR 5 MINUTES, FOLLOWED BY WATER QUENCH,
MONEL, QQ-N-281 ANNEALED
COPPER, QQ-W-343 ANNEALED

2 FINISH. CARBON STEEL CADMIUM PLATE IN ACCORDANCE WITH QQ-P-416 TYPE II, CLASS 3, OR BLACK OXIDE COATING PER MIL-C-13924 CLASS 1
MONEL, WHEN SPECIFIED CADMIUM PLATE IN ACCORDANCE WITH QQ-P-416 TYPE II CLASS 3

(H) 3 SHEAR STRENGTH. CORROSION-RESISTANT STEEL, 65 000 PSI TO 85,000 PSI
CARBON STEEL 38 000 PSI TO 48 000 PSI
MONEL, 49 000 PSI TO 59,000 PSI
COPPER 23,000 PSI TO 27 000 PSI

4 RIVETS SHALL DRIVE COLD SATISFACTORILY WITH A FULL HEAD FREE FROM CRACKS

5 RIVETS MUST BE TRUE TO FORM CONCENTRIC AND FREE FROM INJURIOUS SCALE, FINS SEAMS AND ALL OTHER INJURIOUS DEFECTS WHEN SPECIFIED ADD "C" IN LIEU OF DASH FOR CADMIUM PLATED MONEL RIVETS

6 PART NUMBERS. THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER TAKEN FROM TABLE II

(H) EXAMPLES OF PART NUMBERS
MS20427-2X2 = RIVET, CARBON STEEL, BLACK OXIDE COATING 1/16 DIAMETER 1/8 LONG
MS20427-2C2 = RIVET CARBON STEEL, CADMIUM PLATED 1/16 DIAMETER, 1/8 LONG
MS20427F2-2 = RIVET CORROSION-RESISTANT STEEL, 1/16 DIAMETER, 1/8 LONG
MS20427M2-2 = RIVET, MONEL, 1/16 DIAMETER 1/8 LONG
MS20427C2-2 = RIVET COPPER, 1/16 DIAMETER 1/8 LONG
MS20427M2C2 = RIVET MONEL CADMIUM PLATED, 1/16 DIAMETER 1/8 LONG
MS20427M3-3-5 = RIVET MONEL, 3/32 DIAMETER 7/32 LONG

7 FOR PART NUMBER OF RIVET LENGTH NOT LISTED ON SHEET 2 SHOW 1/16 INCREMENT REQUIRED, 1/32 INCREMENTS MAY BE OBTAINED BY ADDING -5 AFTER LAST DASH NUMBER.

NOTES.

1 DIMENSIONS IN INCHES ANGLE TOLERANCE ±5°

2 DIMENSIONS øA, øA AND B ARE INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY AND ARE NOT TO BE USED FOR INSPECTION PURPOSES VALUES øA, øA, AND B ARE CALCULATED LIMITS RESULTING FROM TOLERANCES ON øW M E AND HEAD ANGLE

3 MS20427 SUPERSEDEDS AN427 IN PART

4 INTERCHANGEABILITY RELATION WITH AN427 RIVETS MS20427 RIVETS AND AN427 RIVETS OF LIKE DASH NUMBERS ARE UNIVERSALLY FUNCTIONALLY AND DIMENSIONALLY INTERCHANGEABLE

5 IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE

6 REFERENCED GOVERNMENT (OR NON-GOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN

(H) DENOTES CHANGE(S)

INCH-POUND

PREPARING ACTIVITY DLA-IS CUSTODIANS ARMY- AR NAVY- AS AIR FORCE- 99 DLA- REVIEW AV, GL, ME USER CE MC PROJECT NUMBER 5320-0814	MILITARY SPECIFICATION SHEET TITLE RIVET, SOLID-100° COUNTERSUNK HEAD, CARBON STEEL, CORROSION-RESISTANT STEEL MONEL AND COPPER	SPECIFICATION SHEET NUMBER MS20427 8 FEB 94 REV H SUPERSEDING MS20427 G 17 JUN 93 (SEE NOTE 3) AMSC- N/A FSC 5320

DISTRIBUTION STATEMENT
A Approved for public release distribution is unlimited

DD Form 672, MAY 88 PREVIOUS EDITIONS ARE OBSOLETE

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODISS SPECIFIED IN THE SOLICITATION NONE

Form Approved
OMB No 0704-0188

TABLE II

CARBON STEEL CADMIUM PLATED	CORROSION RESISTANT STEEL	MONEL	COPPER	LENGTH
DASH NO	DASH NO	DASH NO	DASH NO	
1/16 NOM DIA				
-2C2	F2-2	M2-2	C2-2	1/8
-2C3	F2-3	M2-3	C2-3	3/16
-2C4	F2-4	M2-4	C2-4	1/4
-2C5	F2-5	M2-5	C2-5	5/16
-2C6	F2-6	M2-6	C2-6	3/8
-2C7	F2-7	M2-7	C2-7	7/16
-2C8	F2-8	M2-8	C2-8	1/2
-2C9	F2-9	M2-9		9/16
-2C10	F2-10	M2-10		5/8
3/32 NOM DIA				
-3C3	F3-3	M3-3	C3-3	3/16
-3C4	F3-4	M3-4	C3-4	1/4
-3C5	F3-5	M3-5	C3-5	5/16
-3C6	F3-6	M3-6	C3-6	3/8
-3C7	F3-7	M3-7	C3-7	7/16
-3C8	F3-8	M3-8	C3-8	1/2
-3C9	F3-9	M3-9		9/16
-3C10	F3-10	M3-10	C3-10	5/8
-3C12	F3-12	M3-12	C3-12	3/4
-3C14	F3-14	M3-14	C3-14	7/8
-3C16	F3-16	M3-16	C3-16	1
1/8 NOM DIA				
		M4-3		3/16
-4C4	F4-4	M4-4	C4-4	1/4
-4C5	F4-5	M4-5	C4-5	5/16
-4C6	F4-6	M4-6	C4-6	3/8
-4C7	F4-7	M4-7	C4-7	7/16
-4C8	F4-8	M4-8	C4-8	1/2
-4C9	F4-9	M4-9		9/16
-4C10	F4-10	M4-10	C4-10	5/8
-4C12	F4-12	M4-12	C4-12	3/4
-4C14	F4-14	M4-14	C4-14	7/8
-4C16	F4-16	M4-16	C4-16	1
-4C18	F4-18	M4-18		1-1/8
-4C20	F4-20	M4-20		1-1/4
-4C22	F4-22	M4-22		1-3/8
-4C24	F4-24	M4-24		1-1/2
-4C28	F4-28	M4-28		1-3/4
5/32 NOM. DIA				
		M5-4		1/4
-5C5	F5-5	M5-5		5/16
-5C6	F5-6	M5-6	C5-6	3/8
-5C7	F5-7	M5-7	C5-7	7/16
-5C8	F5-8	M5-8	C5-8	1/2
-5C9	F5-9	M5-9		9/16
-5C10	F5-10	M5-10	C5-10	5/8
		M5-11		11/16
-5C12	F5-12	M5-12	C5-12	3/4
-5C14	F5-14	M5-14	C5-14	7/8
-5C16	F5-16	M5-16	C5-16	1
-5C18	F5-18	M5-18		1-1/8
-5C20	F5-20	M5-20		1-1/4
-5C22	F5-22	M5-22		1-3/8
-5C24	F5-24	M5-24		1-1/2
-5C28	F5-28	M5-28		1-3/4
-5C32	F5-32	M5-32		2

CARBON STEEL CADMIUM PLATED	CORROSION RESISTANT STEEL	MONEL	COPPER	LENGTH
DASH NO	DASH NO	DASH NO	DASH NO	
3/16 NOM DIA				
-6C6	F6-6	M6-6	C6-6	3/8
-6C7	F6-7	M6-7	C6-7	7/16
-6C8	F6-8	M6-8	C6-8	1/2
-6C9	F6-9	M6-9		9/16
-6C10	F6-10	M6-10	C6-10	5/8
-6C12	F6-12	M6-12	C6-12	3/4
-6C14	F6-14	M6-14	C6-14	7/8
-6C16	F6-16	M6-16	C6-16	1
-6C18	F6-18	M6-18	C6-18	1-1/8
-6C20	F6-20	M6-20	C6-20	1-1/4
-6C22	F6-22	M6-22	C6-22	1-3/8
-6C24	F6-24	M6-24	C6-24	1-1/2
-6C28	F6-28	M6-28		1-3/4
-6C32	F6-32	M6-32		2
-6C40	F6-40	M6-40		2-1/2
-6C48	F6-48	M6-48		3
1/4 NOM. DIA				
-8C8	F8-8	M8-8		1/2
-8C9	F8-9	M8-9		9/16
-8C10	F8-10	M8-10		5/8
-8C12	F8-12	M8-12		3/4
-8C14	F8-14	M8-14		7/8
-8C16	F8-16	M8-16		1
-8C18	F8-18	M8-18		1-1/8
-8C20	F8-20	M8-20		1-1/4
-8C22	F8-22	M8-22		1-3/8
-8C24	F8-24	M8-24		1-1/2
-8C28	F8-28	M8-28		1-3/4
-8C32	F8-32	M8-32		2
-8C40	F8-40	M8-40		2-1/2
-8C48	F8-48	M8-48		3
5/16 NOM DIA				
-10C10	F10-10	M10-10		5/8
-10C12	F10-12	M10-12		3/4
-10C14	F10-14	M10-14		7/8
-10C16	F10-16	M10-16		1
-10C18	F10-18	M10-18		1-1/8
-10C20	F10-20	M10-20		1-1/4
-10C22	F10-22	M10-22		1-3/8
-10C24	F10-24	M10-24		1-1/2
-10C28	F10-28	M10-28		1-3/4
-10C32	F10-32	M10-32		2
-10C40	F10-40	M10-40		2-1/2
-10C48	F10-48	M10-48		3
3/8 NOM DIA				
-12C12	F12-12	M12-12		3/4
-12C14	F12-14	M12-14		7/8
-12C16	F12-16	M12-16		1
-12C18	F12-18	M12-18		1-1/8
-12C20	F12-20	M12-20		1-1/4
-12C22	F12-22	M12-22		1-3/8
-12C24	F12-24	M12-24		1-1/2
-12C28	F12-28	M12-28		1-3/4
-12C32	F12-32	M12-32		2
-12C40	F12-40	M12-40		2-1/2
-12C48	F12-48	M12-48		3

PREPARING ACTIVITY DLA-IS
CUSTODIANS ARMY- AR NAVY- AS
AIR FORCE- 99 DLA-
REVIEW AV GL ME
USER CE MC
PROJECT NUMBER 5320-0814

MILITARY SPECIFICATION SHEET

TITLE
RIVET, SOLID-100° COUNTERSUNK HEAD, CARBON STEEL, CORROSION-RESISTANT STEEL, MONEL AND COPPER

SPECIFICATION SHEET NUMBER
MS20427 — 8 FEB 94 REV H

SUPERSEDING
MS20427 G — 17 JUN 93 (SEE NOTE 3)

AMSC- N/A FSC 5320

DISTRIBUTION STATEMENT
A Approved for public release distribution is unlimited

DD Form 672, MAY 88 PREVIOUS EDITION ARE OBSOLETE