

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 DODDS SPECIFIED IN THE SOLICITATION

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

Form Approved
OMB No 0704-0188

NOM DIA	#D		#A		B REF	C		E REF	F REF	R RAD	S	T RAD
	MIN	MAX	MIN	MAX		MIN	MAX					
1/16	.061	.065	.119	.131	.094	.027	.037	.031	.016	.054	.016	.019
3/32	.093	.097	.178	.196	.141	.040	.050	.047	.023	.082	.023	.029
1/8	.124	.128	.238	.262	.188	.054	.064	.062	.031	.108	.031	.039
5/32	.155	.160	.296	.328	.234	.067	.077	.078	.039	.135	.039	.049
3/16	.186	.191	.356	.394	.281	.080	.090	.094	.047	.164	.047	.059
1/4	.249	.254	.475	.525	.375	.107	.117	.125	.062	.217	.062	.078
5/16	.311	.316	.594	.658	.469	.133	.143	.156	.078	.272	.078	.098
3/8	.374	.379	.713	.787	.562	.161	.171	.188	.094	.328	.094	.117
7/16	.436	.442	.832	.918	0.625	.189	.199	.219	.109	.383	.110	.137

REQUIREMENTS

- MATERIAL** STEEL, CARBON COMPOSITION C1005 THRU C1015, (UNSG10050 THRU UNS G10150) IN ACCORDANCE WITH ASTM A29/A29M ANNEALED AFTER HEADING
STEEL, CORROSION RESISTANT, CLASS 300 SERIES, IN ACCORDANCE WITH ASTM A380, ANNEALED AFTER HEADING
- PROTECTIVE COATING** STEEL, CARBON CADMIUM PLATED PER QQ-P-416, TYPE II, CLASS 2
STEEL, CORROSION RESISTANT, CLEANED DESCALE AND PASSIVATE IN ACCORDANCE WITH QQ-P-35
- SHEAR STRENGTH** CARBON STEEL, 38,000 TO 48,000 PSI
CORROSION RESISTANT STEEL, 85,000 TO 85,000 PSI
- TOLERANCES** UNLESS OTHERWISE SPECIFIED DECIMALS ± 0.10
- CONCENTRICITY** SHANK AND HEAD DIAMETERS SHALL BE CONCENTRIC WITHIN
0.10 FIM FOR RIVET SIZES .062 THRU .125
0.15 FIM FOR RIVET SIZES .156 AND .188
0.20 FIM FOR RIVET SIZES .250 THRU .438
- PART NUMBER** THE PART NUMBER SHALL CONSIST OF THE BASIC MS SHEET NUMBER FOLLOWED BY A DASH NUMBER SIGNIFYING THE NOMINAL DIAMETER IN THIRTY-SECONDS OF AN INCH INCREMENTS FOLLOWED BY A LETTER INDICATING THE REQUIRED MATERIAL AND AN ADDITIONAL NUMBER SIGNIFYING THE NOMINAL LENGTH IN SIXTEENTH OF AN INCH INCREMENTS

EXAMPLE MS20613-2 P 2

NOMINAL LENGTH (1/16" INCREMENTS)

MATERIAL
P-CARBON STEEL
C-CORROSION RESISTANT STEEL

NOMINAL DIAMETER (1/32" INCREMENTS)

BASIC MS SHEET NUMBER

MS20613-2P2 - INDICATES RIVET SOLID-UNIVERSAL HEAD CARBON STEEL, CADMIUM PLATED 1/16" NOMINAL DIAMETER 1/8" NOMINAL LENGTH

(F) ENTIRE STANDARD REVISED

INCH-POUND

PREPARING ACTIVITY DLA-IS CUSTODIANS ARMY-AR NAVY-OS AIR FORCE-99 DLA- REVIEW USER PROJECT NUMBER 5320-0813 DISTRIBUTION STATEMENT	MILITARY SPECIFICATION SHEET TITLE RIVET, SOLID-UNIVERSAL HEAD, STEEL, CARBON AND STEEL, CORROSION-RESISTANT	SPECIFICATION SHEET NUMBER MS20613 8 FEB 94 REV F SUPERSEDING MS20613 E 13 JAN 89 (SEE NOTE B) AMSC- N/A FSC 5320
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A Approved for public release distribution is unlimited

Page 1 of 3

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 "DOISS" SPECIFIED IN THE SOLICITATION

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NOTES

- 1 DIMENSIONS DIMENSIONS ARE IN INCHES
- 2 RIVETS MAY BE FURNISHED WITH PLAIN ENDS OR WITH CHAMFERED END WITH A RADIUS TO THE "T" DIMENSIONS OR A 20° CHAMFER TO THE "S" DIMENSION
- 3 ILLUSTRATIONS ARE FOR IDENTIFICATION AND ARE NOT INTENDED TO RESTRICT DESIGNS AND SHAPES OF RIVETS WHICH OTHERWISE CONFORM TO REQUIREMENTS
- 4 UNPLATED CARBON STEEL RIVETS AND ZINC PLATED RIVETS INACTIVE FOR DESIGN AFTER 23 DECEMBER 1960 MS20613 REPLACED THE INACTIVE MS20435 RIVETS OF THE SAME DIAMETER LENGTH AND MATERIAL ON 23 DECEMBER 1960
- 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 (DOISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN
- 7 FOR THE DESIGN FEATURE PURPOSES THIS STANDARD TAKES PRECEDENCE OVER ACQUISITIONS DOCUMENTS REFERENCED HEREIN
- 8 MS20613 SUPERSEDES MS20435 IN PART

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TABLE II DASH NUMBERS AND DIMENSIONS

LENGTH		CARBON STEEL								
		NOMINAL DIAMETERS								
		062	094	125	156	188	250	312	375	438
		DASH NUMBERS								
1/8	125	2P2		4P3		6P4				
3/16	188	2P3	3P3	4P4	5P4	6P5	8P5			
1/4	250	2P4	3P4	4P5	5P5	6P6	8P6			
5/16	312	2P5	3P5	4P6	5P6	6P7	8P7			
3/8	375	2P6	3P6	4P7	5P7	6P8	8P8			
7/16	438	2P7	3P7	4P8	5P8					
1/2	500	2P8	3P8							
9/16	562									
5/8	625			4P10	5P10	6P10	8P10	10P10		
3/4	750		3P12	4P12	5P12	6P12	8P12	10P12		
7/8	875		3P14	4P14	5P14	6P14	8P14	10P14		
1	1000		3P16	4P16	5P16	6P16	8P16	10P16	12P16	14P16
1-1/8	1125									
1-1/4	1250			4P20	5P20	6P20	8P20	10P20	12P20	14P20
1-3/8	1375									
1-1/2	1500			4P24	5P24	6P24	8P24	10P24	12P24	14P24
1-3/4	1750				5P28	6P28	8P28	10P28	12P28	14P28
2	2000				5P32	6P32	8P32	10P32	12P32	14P32

TABLE III DASH NUMBERS AND DIMENSIONS

LENGTH		CARBON STEEL								
		NOMINAL DIAMETERS								
		062	094	125	156	188	250	312	375	438
		DASH NUMBERS								
1/8	125	2C2		4C3		6C4				
3/16	188	2C3	3C3	4C4	5P4	6C5	8C5			
1/4	250	2C4	3C4	4C5	5C5	6C6	8C6			
5/16	312	2C5	3C5	4C6	5C6	6C7	8C7			
3/8	375	2C6	3C6	4C7	5C7	6C8	8C8			
7/16	438	2C7	3C7	4C8	5C8					
1/2	500	2C8	3C8							
9/16	562									
5/8	625			4C10	5C10	6C10	8C10	10C10		
3/4	750		3C12	4C12	5C12	6C12	8C12	10C12		
7/8	875		3C14	4C14	5C14	6C14	8C14	10C14		
1	1000		3C16	4C16	5C16	6C16	8C16	10C16	12C16	14C16
1-1/8	1125									
1-1/4	1250			4C20	5C20	6C20	8C20	10C20	12C20	14C20
1-3/8	1375									
1-1/2	1500			4C24	5C24	6C24	8C24	10C24	12C24	14C24
1-3/4	1750				5C28	6C28	8C28	10C28	12C28	14C28
2	2000				5C32	6C32	8C32	10C32	12C32	14C32

PREPARING ACTIVITY DLA-IS

CUSTODIANS ARMY- AR

NAVY- OS

AIR FORCE- 99

DLA-

MILITARY SPECIFICATION SHEET

TITLE

RIVET, SOLID-UNIVERSAL HEAD
STEEL, CARBON AND STEEL,
CORROSION-RESISTANT

SPECIFICATION SHEET NUMBER

MS20613

8 FEB 94
REV F

SUPERSEDING

MS20613 E 13 JAN 89 (SEE NOTE 8)

AMSC- N/A

FSC 5320

PROJECT NUMBER 5320-0813

DISTRIBUTION STATEMENT

A Approved for public release distribution is unlimited

Page 2 of 3

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

PREPARING ACTIVITY DLA-15 CUSTODIANS ARMY- AR NAVY- OS AIR FORCE- 99 DLA- REVIEW USER PROJECT NUMBER 5320-0813 DISTRIBUTION STATEMENT A Approved for public release distribution is unlimited	<u>MILITARY SPECIFICATION SHEET</u> TITLE RIVET SOLID-UNIVERSAL HEAD, STEEL, CARBON AND STEEL, CORROSION-RESISTANT	SPECIFICATION SHEET NUMBER MS20613 8 FEB 94 REV F SUPERSEDING MS20613 E 13 JAN 89 (SEE NOTE B) AMSC- N/A FSC 5320 Page 3 of 3
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