

INCH-POUND

MIL-R-24243/1E

22 June 1994

SUPERSEDING

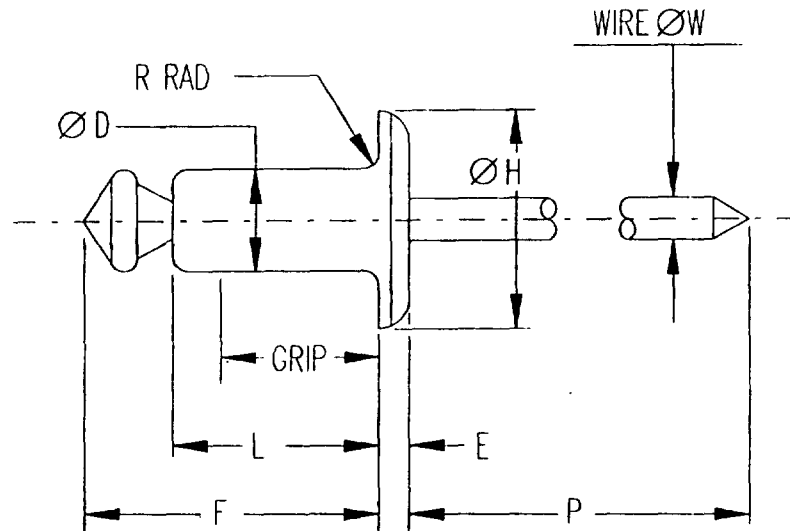
MIL-R-24243/1D

21 September 1987

MILITARY SPECIFICATION SHEET**RIVETS, BLIND, NONSTRUCTURAL, RETAINED MANDREL,
OPEN END, DOMED HEAD, ALUMINUM ALLOY,
CARBON STEEL, CORROSION RESISTANT STEEL**

This specification is approved for use by all Departments and Agencies of the Department of Defense.

The requirements for acquiring the retained mandrel, nonstructural, blind rivets described herein shall consist of this specification and the latest issue of MIL-R-24243.

**NOTES:**

1. All dimensions are in inches.

FIGURE 1. RIVETS**REQUIREMENTS:**

1. Material. Blind rivets shall be furnished in the following material combinations and dimensions.

AMSC N/A

FSC 5320

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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TABLE I. MATERIAL COMBINATION SYMBOLS

SYMBOL	COMBINATION	
	BODY	MANDREL
A	5056 Aluminum Alloy (UNS A95056)	1006-1038 Steel (UNS G10060-G10380)
B	5052 Aluminum Alloy (UNS A95052)	2024 Aluminum Alloy (UNS A92024)
D	1006-1010 Steel (UNS G10060-G10100)	1030-1060 Steel (UNS G10300-G10600)
F	302-HQ-CRES (UNS S30430) 302 CRES (UNS S30200) 305 CRES (UNS S30500)	305-431 CRES (UNS S30500-S43100)
G	302-HQ-CRES (UNS S30430) 302 CRES (UNS S30200) 305 CRES (UNS S30500)	1030-1060 Steel (UNS G10300-G10600)

TABLE II. BASIC DIMENSIONS

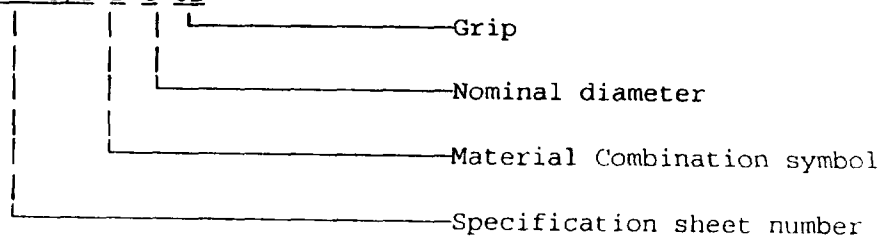
NOM DIA	BASIC DIMENSIONS							RECOMMENDED HOLE SIZE
	ØD	H	E	R MAX	W NOM	F MAX	P MIN	
.094	.096 .090	.198 .178	.032 .022	.015	.057	L MAX +.100	1.00	.097-.100
.125	.128 .122	.262 .238	.040 .030	.020	.076	L MAX +.120	1.00	.129-.133
.156	.159 .153	.328 .296	.050 .037	.020	.095	L MAX +.140	1.00	.160-.164
.188	.191 .183	.394 .356	.060 .045	.025 1/	.114	L MAX +.160	1.00	.192-.196
.250	.255 .246	.525 .475	.080 .065	.030 2/	.151	L MAX +.180	1.00	.257-.261

1/ For material combinations F and G, R Max shall be .035.

2/ For material combinations F and G, R Max shall be .060.

2. Part Number. The part number shall consist of the letter "M", the basic number of this specification sheet, followed by a dash number consisting of a material combination symbol, a nominal body diameter size code in thirty-seconds of an inch, and a maximum grip code in sixteenths of an inch taken from Table III.

EXAMPLE: M24243/1 B 4 02



M24243/1B402 Indicates - Rivet, blind, nonstructural, retained mandrel, open-end, domed head, 5052 (UNS A95052) aluminum body, 2024 (UNS A92024) aluminum mandrel; nominal body diameter size, .125; grip range, .063-.125.

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3. Changes from previous issues. Asterisks are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

TABLE III. DASH NUMBERS AND DIMENSIONS

DASH NUMBER					L	RECOMMENDED GRIP RANGE
A302	B302	D302	F302	G302	.228-.250	.020-.125
A304	B304	D304	F304	G304	.340-.375	.126-.250
	B306				.470-.500	.251-.375
A401	B401	D401			.182-.212	.020-.062
A402	B402	D402	F402	G402	.245-.275	.063-.125
A403	B403	D403	F403	G403	.307-.337	.126-.187
A404	B404	D404	F404	G404	.370-.400	.188-.250
A405	B405	D405			.432-.462	.251-.312
A406	B406	D406	F406	G406	.495-.525	.313-.375
A408	B408	D408	F408	G408	.620-.650	.376-.500
A502	B502	D502	F502	G502	.270-.300	.020-.125
A503	B503	D503	F503	G503	.332-.362	.126-.187
A504	B504	D504	F504	G504	.395-.425	.188-.250
A506	B506	D506	F506	G506	.530-.550	.251-.375
A508	B508	D508	F508	G508	.645-.675	.376-.500
A602	B602	D602	F602	G602	.295-.325	.020-.125
A604	B604	D604	F604	G604	.420-.450	.188-.250
A606	B606	D606	F606	G606	.545-.575	.251-.375
A608	B608	D608	F608	G608	.670-.700	.376-.500
A610	B610	D610	F610	G610	.795-.825	.501-.625
A612	B612	D612	F612	G612	.920-.950	.626-.750
A616	B616				1.170-1.200	.876-1.000
A804	B804	D804	F804	G804	.470-.500	.126-.250
A806	B806	D806	F806	G806	.595-.625	.251-.375
A808	B808	D808	F808	G808	.720-.750	.376-.500
A810	B810		F810	G810	.845-.875	.501-.625
A812	B812	D812	F812	G812	.970-1.00	.626-.750
		D816			1.220-1.250	.876-1.000

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Custodians:

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Navy - AS

Air Force - 99

Preparing Activity:

DLA-IS

Review Activities:

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Air Force - 82

National Security Agency - NS

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