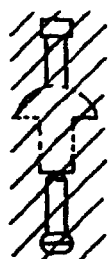
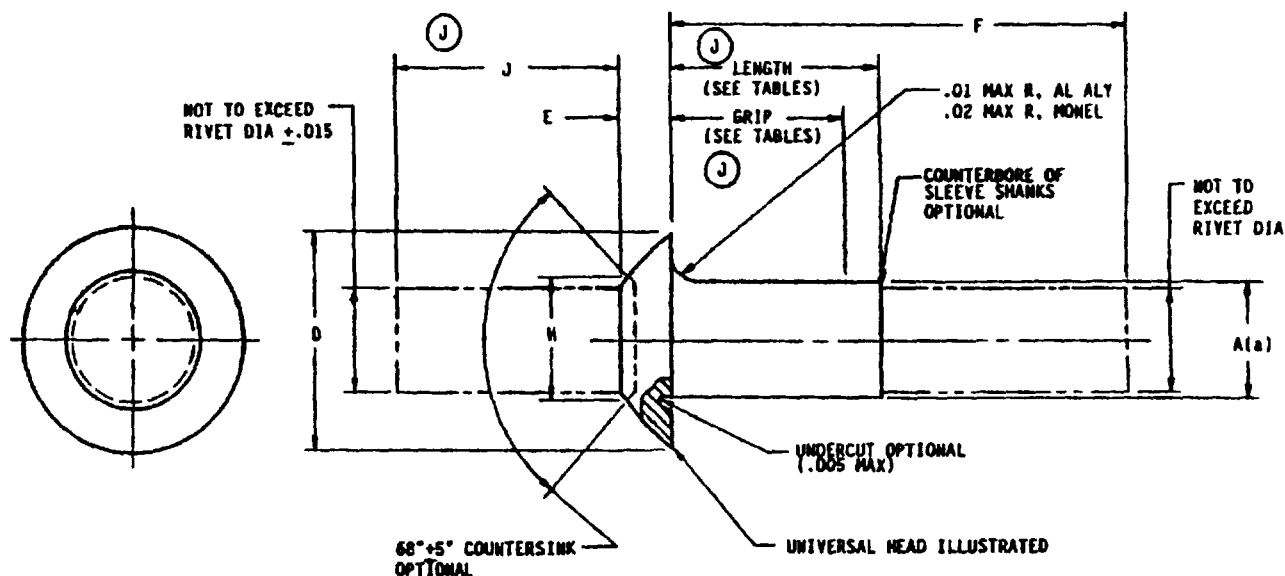


THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODISS SPECIFIED IN THE SOLICITATION MIL-R-7885



K KNOB SYSTEM



M SERRATED STEM

## RIVET IDENTIFICATION CODE

J TABLE I. DIMENSIONS.

RIVET SIZE NON DIA	A +.003 -.001 DIA	UNIVERSAL HEAD		H MAX DIA	J MIN
		B DIA	E +.010 -.000		
1/8	.125	.250 $\pm$ .012	.064	.110	0.750
5/32	.156	.312 $\pm$ .016	.067	.138	0.750
3/16	.187	.375 $\pm$ .019	.080	.161	0.750
1/4	.250	.500 $\pm$ .025	.107	.215	1.000

(a) .001 SHANK DIA INCREASE PERMISSIBLE WITHIN .100 INCH OF BASE OF HEAD.

J DENOTES CHANGES

THIS SPECIFICATION IS A  
MILITARY SPECIFICATION  
FOR THE USE OF ALL  
DEPARTMENTS AND  
AGENCIES OF THE  
DEPARTMENT OF DEFENSE

PREPARING ACTIVITY NAVY-AS  
CUSTODIANS ARMY-AR NAVY-  
AIR FORCE-99 DLA-  
REVIEW ARMY-ER, AV, MI NAVY-SH DLA-IS  
AIR FORCE 82  
PROJECT NUMBER 5320-0769

MILITARY SPECIFICATION SHEET  
TITLE RIVET, BLIND, STRUCTURAL  
PULL STEM, SELF-PLUGGING,  
PROTRUDING HEAD, TYPE II

SPECIFICATION SHEET NUMBER 10 AUG 92  
MS20600 REV J  
SUPERSEDING  
MS20600, REV H, 11 DEC 89  
AMSC- N/A FSC 5320

## W-SERRATED STEM

Form approved  
OMB No. 0704-0188

TABLE II 1/8 RIVET DIAMETER (NOMINAL), PART NUMBERS AND DIMENSIONS

2117 AL DASH NO.	5056 AL DASH NO.	MODEL DASH NO.	MODEL, CADMIUM PLATED DASH NO.	GRIP RANGE		LENGTH MAX	F MAX
				MIN	MAX		
AD4W1	B4W1	MS4W1	MP4W1	UP TO .062		.170	.900
AD4W2	B4W2	MS4W2	MP4W2	.063	.125	.155	.900
AD4W3	B4W3	MS4W3	MP4W3	.126	.187	.255	.750
AD4W4	B4W4	MS4W4	MP4W4	.188	.250	.357	.750
AD4W5	B4W5	MS4W5	MP4W5	.251	.312	.480	1.010
AD4W6	B4W6	MS4W6	MP4W6	.313	.375	.482	1.100
AD4W7	B4W7	MS4W7	MP4W7	.376	.437	.545	1.187
AD4W8	B4W8	MS4W8	MP4W8	.438	.500	.607	1.322
AD4W9	B4W9	MS4W9	MP4W9	.501	.562	.670	1.609
AD4W10	B4W10	MS4W10	MP4W10	.563	.625	.722	1.600
AD4W11	B4W11	MS4W11	MP4W11	.626	.687	.785	1.780
AD4W12	B4W12	MS4W12	MP4W12	.688	.750	.847	1.888

TABLE III 5/32 RIVET DIAMETER (NOMINAL), PART NUMBERS AND DIMENSIONS

2117 AL DASH NO.	5056 AL DASH NO.	MODEL DASH NO.	MODEL, CADMIUM PLATED DASH NO.	GRIP RANGE		LENGTH MAX	F MAX
				MIN	MAX		
AD5W1	B5W1	MS5W1	MP5W1	UP TO .062		.192	.558
AD5W2	B5W2	MS5W2	MP5W2	.063	.125	.154	.620
AD5W3	B5W3	MS5W3	MP5W3	.126	.187	.317	.804
AD5W4	B5W4	MS5W4	MP5W4	.188	.250	.379	.870
AD5W5	B5W5	MS5W5	MP5W5	.251	.312	.441	1.058
AD5W6	B5W6	MS5W6	MP5W6	.313	.375	.505	1.120
AD5W7	B5W7	MS5W7	MP5W7	.376	.437	.567	1.359
AD5W8	B5W8	MS5W8	MP5W8	.438	.500	.639	1.461
AD5W9	B5W9	MS5W9	MP5W9	.501	.562	.682	1.547
AD5W10	B5W10	MS5W10	MP5W10	.563	.625	.754	1.630
AD5W11	B5W11	MS5W11	MP5W11	.626	.687	.817	1.817
AD5W12	B5W12	MS5W12	MP5W12	.688	.750	.879	1.880
AD5W13	B5W13	MS5W13	MP5W13	.751	.812	.942	2.067
AD5W14	B5W14	MS5W14	MP5W14	.813	.875	1.004	2.130

TABLE IV 3/16 RIVET DIAMETER (NOMINAL), PART NUMBERS AND DIMENSIONS

2117 AL DASH NO.	5056 AL DASH NO.	MODEL DASH NO.	MODEL, CADMIUM PLATED DASH NO.	GRIP RANGE		LENGTH MAX	F MAX
				MIN	MAX		
AD3W1	B3W1	MS3W1	MP3W1	UP TO .062		.215	.638
AD3W2	B3W2	MS3W2	MP3W2	.063	.125	.277	.780
AD3W3	B3W3	MS3W3	MP3W3	.126	.187	.340	.888
AD3W4	B3W4	MS3W4	MP3W4	.188	.250	.402	.950
AD3W5	B3W5	MS3W5	MP3W5	.251	.312	.463	1.118
AD3W6	B3W6	MS3W6	MP3W6	.313	.375	.527	1.280
AD3W7	B3W7	MS3W7	MP3W7	.376	.437	.580	1.418
AD3W8	B3W8	MS3W8	MP3W8	.438	.500	.653	1.581
AD3W9	B3W9	MS3W9	MP3W9	.501	.562	.714	1.737
AD3W10	B3W10	MS3W10	MP3W10	.563	.625	.777	1.899
AD3W11	B3W11	MS3W11	MP3W11	.626	.687	.840	1.887
AD3W12	B3W12	MS3W12	MP3W12	.688	.750	.902	1.949
AD3W13	B3W13	MS3W13	MP3W13	.751	.812	.965	2.074
AD3W14	B3W14	MS3W14	MP3W14	.813	.875	1.027	2.199

TABLE V 1/4 RIVET DIAMETER (NOMINAL), PART NUMBERS AND DIMENSIONS

2117 AL DASH NO.	5056 AL DASH NO.	MODEL DASH NO.	MODEL, CADMIUM PLATED DASH NO.	GRIP RANGE		LENGTH MAX	F MAX
				MIN	MAX		
AD2W1	B2W1	MS2W1	MP2W1	.125	.187	.385	.970
AD2W2	B2W2	MS2W2	MP2W2	.188	.250	.447	1.090
AD2W3	B2W3	MS2W3	MP2W3	.251	.312	.510	1.230
AD2W4	B2W4	MS2W4	MP2W4	.313	.375	.572	1.340
AD2W5	B2W5	MS2W5	MP2W5	.376	.437	.635	1.470
AD2W6	B2W6	MS2W6	MP2W6	.438	.500	.697	1.590
AD2W7	B2W7	MS2W7	MP2W7	.501	.562	.760	1.730
AD2W8	B2W8	MS2W8	MP2W8	.563	.625	.822	1.848
AD2W9	B2W9	MS2W9	MP2W9	.626	.687	.885	1.970
AD2W10	B2W10	MS2W10	MP2W10	.688	.750	.947	2.090
AD2W11	B2W11	MS2W11	MP2W11	.751	.812	1.010	2.230
AD2W12	B2W12	MS2W12	MP2W12	.813	.875	1.072	2.340
AD2W13	B2W13	MS2W13	MP2W13	.876	.937	1.134	2.403
AD2W14	B2W14	MS2W14	MP2W14	.938	1.000	1.196	2.530

PREPARING ACTIVITY NAVY-AS  
CUSTODIANS ARMY-AR NAVY-  
NR FORCE-99 DLA-  
REVIEW ARMY-ER, AV, MI NAVY-SH DLA-IS  
AIR FORCE 82  
PROJECT NUMBER 5320-0760

MILITARY SPECIFICATION SHEET  
TITLE RIVET, BLIND, STRUCTURAL  
PULL STEM, SELF-PLUGGING,  
PROTRUDING HEAD, TYPE II

SPECIFICATION SHEET NUMBER  
**MS20600**  
SUPERSEDING  
MS20600, REV H, 11 DEC 89

10 AUG 92  
REV J

**(J) REQUIREMENTS:**

1. MATERIAL: SLEEVES; AL ALLOY, COMP 2117, QQ-A-430.  
AL ALLOY, COMP 5056, QQ-A-430.  
NICKEL-COPPER-ALLOY (MONEL), CLASS A, QQ-N-281.  
PINS; AL ALLOY, COMP 2017, QQ-A-430.  
AL ALLOY, COMP 5056, QQ-A-430.  
NICKEL-COPPER-ALLOY (MONEL), CLASS A, QQ-N-281.
2. FINISH: ALUMINUM ALLOY; ANODIZE IN ACCORDANCE WITH MIL-A-8625 OR CHEMICALLY SURFACE TREAT IN ACCORDANCE WITH MIL-C-5541.  
NICKEL-COPPER-ALLOY (MONEL); CADMIUM-PLATED IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.  
~~NO LETTER AFTER MATERIAL DESIGNATION INDICATES NO FINISH REQUIRED.~~
3. COLOR. 5056 ALUMINUM ALLOY RIVETS SHALL BE SUITABLY IDENTIFIED BY AN ORANGE COLOR IN ACCORDANCE WITH FEDERAL STANDARD NUMBER 596, COLOR NUMBER 32246.
4. ADD "AD" IN PLACE OF DASH TO INDICATE ALUMINUM ALLOY, COMPOSITION 2117.  
ADD "B" IN PLACE OF DASH TO INDICATE ALUMINUM ALLOY, COMPOSITION 5056.  
ADD "M" IN PLACE OF DASH TO INDICATE NICKEL-COPPER-ALLOY (MONEL).  
~~ADD "ML" IN PLACE OF DASH TO INDICATE NICKEL-COPPER-ALLOY (MONEL) SILVER-PLATED.~~  
ADD "P" AFTER MATERIAL DESIGNATION TO INDICATE CADMIUM PLATE.
5. ~~ADD IDENTIFICATION CODE LETTERS AFTER DASH NUMBER TO INDICATE TYPE OF RIVET BASED ON METHOD OF INSTALLATION.~~  
~~ADD "K" TO INDICATE KNOB STEM RIVET.~~  
~~ADD "S" TO INDICATE SERRATED STEM RIVET.~~  
~~NO LETTER INDICATES A COMPLETE RIVET WITH TYPE OF STEM OPTIONAL. INACTIVE FOR DESIGN AFTER 21 MARCH 1962.~~  
~~CANCELLED AFTER 1 FEBRUARY 1968.~~

**(J) NOTES:**

1. EXAMPLES OF PART NUMBERS:  
MS20600 ADSMS = RIVET, 2117 ALUMINUM ALLOY SLEEVE, .156 DIA, SERRATED STEM, .251 TO .312 GRIP RANGE.  
MS20600 BSMS = RIVET, 5056 AL ALLOY SLEEVE, .156 DIA, SERRATED STEM, .251 TO .312 GRIP RANGE.  
MS20600 MPSMS = RIVET, NICKEL-ALLOY (MONEL) SLEEVE, CADMIUM-PLATED, .156 DIA, SERRATED STEM, .251 TO .312 GRIP RANGE.
2. DIMENSIONS ARE IN INCHES, UNLESS OTHERWISE SPECIFIED.
- (J)** 3. FOR QUALIFIED PRODUCTS, SEE QPL-7885.
4. FOR DESIGN USAGE LIMITATIONS, USE MS33522.
5. SILVER-PLATED NICKEL-COPPER-ALLOY (MONEL) (SERIES ML) RIVETS SHALL BE INACTIVE FOR DESIGN AFTER (DATE). USE EXISTING STOCK UNTIL DEPLETED. USE MONEL (SERIES M) OR CADMIUM-PLATED MONEL (SERIES MP) RIVETS IDENTIFIED BY THE SAME DASH NUMBER. KNOB STEM RIVETS (SERIES K) AND "NO LETTER RIVETS" INACTIVE FOR DESIGN AFTER 21 MARCH 1962, USE MS20600, SHEET 2, SERRATED STEM RIVETS (SERIES M). KNOB STEM RIVETS (SERIES K) WILL BE CANCELLED FROM THIS STANDARD 21 MARCH 1968.
6. INTERCHANGEABILITY RELATIONSHIP: SERRATED STEM RIVETS (SERIES M) ARE UNIVERSALLY, FUNCTIONALLY, AND DIMENSIONALLY INTERCHANGEABLE WITH KNOB STEM RIVETS (SERIES K) WITH PROPER TOOLING.
7. KNOB STEM RIVETS (SERIES K) SHOULD BE USED UNTIL EXISTING STOCK IS DEPLETED.  
~~MONEL RIVETS IDENTIFIED BY M INACTIVE FOR DESIGN AFTER 1 FEBRUARY 1968. USE RIVETS IDENTIFIED BY ML (MONEL, SILVER-PLATED).~~
8. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

PREPARING ACTIVITY: NAVY - AS

CUSTODIANS ARMY - AR

NAVY -

AIR FORCE - 99

DLA -

## MILITARY SPECIFICATION SHEET

TITLE RIVET, BLIND, STRUCTURAL  
PULL STEM, SELF-PLUGGING.

SPECIFICATION SHEET NUMBER

MS20600

10 AUG 92

REV J

SUPERSEDING

MS20600

REV H

11 SEP 92

(J) TABLE VI. INTERCHANGEABILITY

INACTIVE PART NUMBERS		SUBSTITUTE PART NUMBERS
MS20604		
MS20604	AD3E	MS20600
	AD4E	AD4W
	AD5E	AD5W
	AD6E	AD6W
	AD8E	AD8W
	B3E	
	B4E	B4W
	B5E	B5W
	B6E	B6W
	B8E	B8W
	ML3E	---
	MP3E	---
	M3E	---
	ML4E	MP4W
	MP4E	MP4W
	M4E	M4W
	ML5E	MP5W
	MP5E	MP5W
	M5E	M5W
	ML6E	MP6W
	MP6E	MP6W
	M6E	M6W
	ML8E	MP8W
	MP8E	MP8W
MS20604	M8E	MS20600 M8W

CORRESPONDING GRIP NUMBERS ARE DIRECTLY INTERCHANGEABLE.

PREPARING ACTIVITY NAVY - AS

CUSTODIANS. ARMY - AR NAVY -  
AIR FORCE - 99 DLA -

REVIEW ARMY - ER, AV, MI NAVY - SH DLA - IS  
USER. AIR FORCE 82

# MILITARY SPECIFICATION SHEET

TITLE RIVET, BLIND, STRUCTURAL  
PULL STEM, SELF-PLUGGING,  
PROTRUDING HEAD, TYPE II

SPECIFICATION SHEET NUMBER

MS20600

10 AUG 92  
REV J

SUPERSEDING

MS20600

REV H

11 DEC 89